FINISH LIST

Suppliers and internal Manufacturing Groups must be in compliance with the latest revision of this document. Therefore, when changes are made to the Finish List or a new finish number added, please notify the:

- Supply Chain Manager to ensure our suppliers are provided the latest revision
- Website Administrator to update Finish List on http://www.hutchinsonai.com/company/forms.cfm
ANODIZE WITH FINISH VARIATIONS

600  Anodize per MIL-A-8625, Type I, Class 1.

601  REV A  Anodize per MIL-8625, Type I – Chromic Acid process or Type II - Sulphuric Acid process, except using clear water seal instead Of Dichromate seal.  
Unless otherwise specified on drawing, anodize is to be  
Class I per MIL-A-8625 non-dyed.

602  Anodize per MIL-A-8625, Type II, Class 1.

603  Dull clear anodize per MIL-A-8625. One coat clear baking  
lacquer, one coat dull clear lacquer.

604  Dull clear anodize per MIL-A-8625. Prime per MIL-P-15328.  
One coat dull black instrument baking enamel per Spec. MIL-E-5557, Type 4.

605  Dull clear anodize per MIL-A-8625, coat clear flat lacquer.

606  Black anodize per MIL-A-8625.

607  Black anodize per Spec. MIL-A-8625, then paint one coat with OST D  
#52 Paint #7. (Black with inhibiting agent added), Source:  
Universal Coating Co. #504.

608  Dull clear anodize per MIL-A-8625. Black paladin primer, fine  
black wrinkle per MIL-E-5558, Type I - apply per MIL-E-7851.

609  Black anodize per MIL-A-8625 and dichromate seal.

610  Chromic acid anodize per MIL-A-8625, one coat zinc-chromate  
primer per MIL-P-6889. Finish with olive drab #2430 per Spec.  
TT-C-595, semi-gloss, air drying enamel, Grade 1 per Spec. 3-174  
(film thickness 1.0 to 1.5 mils dry thickness per Spec. 72-53, Par. E-2-B).

611  Identical to Finish No. 604, except masking required as per drawing.
Dull clear anodize per MIL-A-8625. One coat zinc chromate primer per MIL-P-6889, and two coats dull black enamel, Munsell N 1.5, Gloss 2-8.

Identical to Finish No. 601, except masking or other specifications required as per drawing.

Identical to Finish No. 606, except masking required as per drawing.

Chromic acid anodize per MIL-A-8625 one coat zinc chromate primer per MIL-P-6889, and two coats black lusterless synthetic enamel, Grade 1 per Spec. 3-173. Masking required as per drawing.

Identical to 608, except masking required as per drawing.

Identical to 953, except masking required as per drawing.

Bright anodize and sulphuric acid anodize per Spec. MIL-A-8625, Type II* (not to be used on assembled parts) *less dichromate seal.

Bright black anodize: ALCOA #R5 chemical brightener and sulphuric acid anodize per Spec. MIL-A-8625, Type II* (not to be used on assembled parts) *less dichromate seal.

Identical to 618, except buffing required as per drawing. Area buffed shall be clean and free of all compounds used in buffing operation.

Dull clear anodize per MIL-A-8625, Type II, one coat zinc chromate primer per MIL-P-6889, silver-gray light hammertone conforming to Color #1645 of Spec. TT-C-595.

Identical to 621, except masking or other qualifications as per drawing.

a. Degrease.
b. Black anodize entirely per MIL-A-8625, Type I.
c. Prime outside surface only with one coat zinc chromate primer per MIL-P-6889, Type I. Bake for 1/2 hour at 250° F.
d. Cover outside surfaces only with one coat dull black enamel (thinned for spraying). Bake for 3 hours at 300° F.

Identical to 619, except buffing required as per drawing.

Sulphuric acid anodize per MIL-A-8625, Type II, except omit sealing.

Dull clear anodize per MIL-A-8625, Type II. One coat zinc chromate primer per MIL-P-6889, blue medium hammertone.
Anodized per MIL-A-8625, and dyed blue.

Dull clear anodize per MIL-A-8625, Type II. One coat zinc chromate primer per MIL-P-6808 on surface indicated on drawing.

Dull clear anodize per MIL-A-8625, Type II. One coat zinc chromate primer per MIL-P-6808.

Finish to 618, then rework per Data Sheet No. 538.

Anodize per MIL-A-8625, Type II; apply light green dye.

Anodize per Spec. MIL-A-8625, Type II (sulphuric acid process). Brush (non-metallic bristle) to remove surface deposits.

Anodize per MIL-A-8625, Type II, glossy paint insignia red color to conform with ANA Bulletin 166, Color No. 509. Masking as required as per drawing.

Same as 633, except insignia blue to conform with ANA Bulletin 166, Color No. 502. Masking required as per drawing.

Same as 633, except orange yellow to conform with ANA Bulletin 166, Color No. 506. Masking required as per drawing.

Same as 633, except green to conform to Spec. TT-C-595, Color No. 1460. Masking required as per drawing.

Black anodize per MIL-A-8625, Type II. Spray with medium coat Kissling Co. #1105 instrument black. Air dry 2 hours. Mask threads or other requirements as per drawing.

Bright anodize Alcoa #R5 chemical brightener, and sulfuric acid anodize per Spec. MIL-A-8625, Type II. *One coat zinc chromate primer per Spec. MIL-P-6889, and one coat of flat black lacquer. Masking or other specifications required as per drawing. *Less dichromate seal.

MISCELLANEOUS FINISHES

Light caustic etch for threaded parts.

REVA Finish P513-C (green semi-gloss enamel, Color No. X24084 per Fed. Std. 595) per Spec. MIL-F-14072, except primer Step 3, which shall be hi-bake Epoxy #828-025, as supplied by E. I. DuPont DeNemours Co., Inc., Wilmington, Delaware. Primer shall be baked 20 minutes at 350° F. Color must conform with color sample in possession of Product Engineering.
641 Phosphate coat with Turco Paintite or equal. One coat Sherwin-Williams Co. Opex Industrial Lacquer #L61Y25, (light yellow). Masking as per drawing.

642 Cadmium plate .0002 thick per QQ-P416, Class 3, Type I, and one coat of primer per MIL-C15328, and two coats of baked gray enamel per MIL-E15090, Type III, Class 1.

643 Hot-tin dip .0005 min. thick per MIL-T-10727, Type II.

644 Prime with Raffi & Swanson #5355-G-36 gray primer. Surfaces should be free of dirt, grease and other foreign substances. Spray with one coat of tweed tone gray, Raffi & Swanson No. 4850G-40; see R & S Teck; Bulletin 111C in possession of special products section.

645 Cadmium plate per QQ-P-416, Type II, Class 1, wash pretreat per MIL-C-15328, zinc chromate primer per MIL-P-8585, two coats of gloss air dry white enamel per TT-E-485, Class A.

646 REVA Passivate per MIL-STD-171 (ORD) Finish #5.4. Prime with zinc chromate primer per latest version of MIL-P-6889. Paint one coat olive drab semi-gloss enamel per TT-E-529, Color No. 24084, per Fed. Std. 595. (Masking or other qualifications required as per drawing).

647 REVA Chromate conversion per MIL-DTL-5541, Class 1A. Prime with zinc chromate primer per MIL-P-6889. Paint 2 coats light gray enamel. (MIL-E-15090, Class 2). Color chip #26440 per FED-STD-595. Masking required as per drawing.

648 REVA Chromate conversion per MIL-DTL-5541, Class 1A. Prime with zinc chromate primer per MIL-P-6889. Paint 2 coats dull black lacquer. Color Chip #37038 (10° max. gloss).

649 Orange Machine Enamel.

650 Brown Machine Enamel.

651 Light Blue Machine Enamel.

652 Gray Machine Enamel.

653 Dark Blue Machine Enamel.

654 Pink Machine Enamel.

655 Purple Machine Enamel.
Black anodize per MIL-A-8625, Type I, zinc chromate primer per MIL-P-8585. Dull black lacquer per MIL-L-6805 painting to conform to MIL-F-7179 and MIL-F-18264 (see drawing for masking requirements).


Same as 832 finish, except add "masking as per drawing."

Zinc plate .0005 thick per FE/ZN 12, Type II of ASTM B 633. Masking required as per drawing, one coat of primer in accordance with TT-P-664 or MIL-P-8585 applied as a continuous film .0002 to .001 inch thick; two coats of light gray baking enamel per MIL-E-15090, Class 2, Type III.

Olive drab paint as per Barry Data Sheet #691.


Finish P213 C (green semi-gloss enamel, E. I. DuPont DeNemours, Type No. 1752-65077, no equivalent is acceptable) per Spec. MIL-F-14072, except primer, Step 3, which shall be Hi-Bake Epoxy #828-025, as supplied by E. I. DuPont DeNemours Company, Inc., Wilmington, Delaware. Primer shall be baked 20 minutes at 350°F. Masking required as per drawing. Color must conform with Collins Color Drift Control Standard No. 385 in possession of Product Engineering Section.

Finish P513 C (green semi-gloss enamel, E. I. DuPont DeNemours, Type No. 1752-65077, no equivalent is acceptable) per Spec. MIL-F-14072, except primer, Step 3, which shall be Hi-Bake Epoxy #828-025, as supplied by E. I. DuPont DeNemours Company, Inc., Wilmington, Delaware. Primer shall be baked 20 minutes at 350°F. Masking required as per drawing. Color must conform with Collins Color Drift Control Standard No. 385 in possession of Product Engineering Section.

Bright alloy plate per Alballoy Process by Hanson-Van Winkle Munning Company, Matawan, New Jersey, or equal.

Passivate per Barry Data Sheet #702.

Passivate per Barry Data Sheet #703.

Silver Plate per QQ-S-365, Type I.

Hot tin dip per Specification MIL-T-10727, Type II, masking as required per drawing.
REVA Zinc plate per ASTM B 633, Type II - FE/ZN12 - plus two (2) coats of paint per MIL-E-15090, Type III - Class 2 - Color 26357 per TT-C-595.

Cad. plate .0005 thick and chromate dip per QQ-P-416, Type II, Class 1. One coat zinc chromate primer per MIL-P-6889; two coats light gray medium air drying enamel, Type I, Class 2, per MIL-E-15090.

Iridite No. 14 (Alcote) per Spec. MIL-DTL-5541.

Iridite No. 14-2 per Spec. MIL-DTL-5541.

Copper flash .0001 max. per MIL-C-14550, silver plate .0003 min. per Finish No. 1.7.3 of MIL-STD-171 (ord.).

Passivate with a phosphate film per MIL-C-490, Grade I. Prime with one coat of zinc chromate, 0.4 to 0.6 MIL (dry film) thick, per MIL-P-8585. Paint one coat semi-gloss enamel gray, No. 2610 per TT-C-595, per TT-E-529. (This finish is per P211F of MIL-F-14072).

Clear, colorless Iridite #14-9 per MIL-DTL-5541.

One coat of zinc chromate primer 0.4 to 0.6 MIL (dry film) thick per MIL-P-8585. One coat semi-gloss enamel green (No. 2430) per TT-C-595 and TT-E-529.

Turco #4178-6 per MIL-DTL-5541, Class 1A. Reference Narco Spec. M-04503-1. (Color to match Narco Color Chip No. M-04503-2, which is retained by Product Eng.)

Cadmium plate per Finish No. 1.1.2.1 of MIL-STD-171. Chemical Finish No. 5.2 per MIL-STD-171. Primer zinc yellow per TT-P-666. 1 coat air dried or baked. Top coat per System No. 21.9, MIL-STD-171, Color No. 26132 per FED-STD-595, Gloss 10° - 17°.

Cadmium plate .0002 thick, Class 3, Type I per QQ-P-416. Paint with red air drying enamel.


Chemical black for stainless steel per R.C.A. Specs. 1980173 and 1980032 (R.C.A. Specs. retained by Prod. Eng. Dept.).

Finish per MIL-F-14072 passivate and zinc chromate primer per MIL-P-8585. Paint semi-gloss enamel, film designation C, Color K No. 2430 per Spec. TT-E-529.
683 Abrasive blast per MIL-C-490, Grade II, Type I, where necessary, then hot dip galvanize per MIL-S-17871, then phosphate treat per MIL-T-12879, Type I, Class 1, then wash pretreat per MIL-C-15328. Zinc chromate primer per MIL-P-8585. One coat of high gloss gray, tinted white, air dry enamel, R.C.A. #2016110-37, followed by one coat of high gloss white, air dry enamel, R.C.A. #2016110-4 per R.C.A. Finish Spec. 1985980-1 (R.C.A. Spec. retained by Prod. Eng. Dept.)

684 White Machine Enamel.

685 Blue Machine Enamel.

686 Alodin 1200 or 1200S per Collins Spec. No. 580-0254-00 (color to be golden brassy iridescence, to a golden brown).

687 REVA Cad. plate .0002 to .0004 inch thick per QQ-P-416, Type II, Class 3. Pretreat with coating MIL-P-15328 per MIL-C-8507, .0002 to .0003 inch DRY FILM THICKNESS. Top coat with TT-E-489, Class A or B GLOSS ENAMEL .001 DRY FILM or enough to hide. Use Color Number 15045 and Federal Standard 595.

688 REVA Aluminum conversion coating per MIL-DTL-5541, Class 1A complete. Prime with one coat of zinc chromate primer 0.4 to 0.6 MIL (DRY FILM) thick per MIL-P-6889. Paint with black non-reflecting enamel conforming to MIL-E-5556 or MIL-E-5557, Type IV. Masking required as per drawing.

689 REVB Zinc plate per ASTM B633, FE/ZN8, Type III and bonderize, plus one coat of zinc chromate primer per MIL-P-8585. Paint two (2) coats semi-gloss olive drab enamel, Color No. 24084 per FED-STD-595.

690 Identical to 871, except masking or other qualifications as per drawing.

691 REVA Oakite Products Inc., chromate process per MIL-DTL-5541, Class 1A. Prime with zinc chromate primer per MIL-P-6889. Paint 2 coats light gray enamel. (MIL-E-15090, Class 2), Color Chip #26440 per FED-STD-595. Apply (1) coat fungus resistant varnish per MIL-V-173 (Brooklyn Paint & Varnish #747). Coat light to minimize yellow tint, but provide complete coverage.
Anodize per MIL-A-8625, Type II, one coat zinc chromate primer per MIL-P-6889. One coat dark gray, semi-gloss enamel, Color No. 26081 per FED-STD-595. Masking required as per drawing.

Phosphate dip, one coat zinc chromate primer per MIL-P-8585, two coats gray enamel per MIL-E-15090, Class 2, masking required as per drawing.

Zinc plate per ASTM B633, FE/ZN5, Type III, one coat zinc chromate primer per MIL-P-8585. Plus two coats of green baking enamel per TT-E-489, Color No. 14223 per FED-STD-595.

Zinc plate (.0005 thick) per QQ-P-416, Type II, Class 1. Prime with one coat of zinc chromate primer per MIL-P-6889. Apply semi-gloss olive drab paint (Color #X24084) per MIL-STD-79.

Chemical film per MIL-DTL-5541, Class 1A and apply two coats Everseal SE-663 flat black epoxy paint, Color No. 36238, to exterior surfaces only, with bake cycle between coats. Masking, if any, as required per drawing.

Chromate conversion (electrically conductive) on aluminum. See Barry Data Sheet #790 (Ref. Raytheon Spec. 296MT051).

Black enamel (flat) bake. See Barry Data Sheet #791 (ref. Raytheon Spec. 296MT211). Masking required as per drawing.

Iridite #14-9 (clear).

Cad plate .0003 min. and clear colorless chromate treat (Iridite #4P-4 or equal) per QQ-P-416, Class 2, Type II.

Cad plate .0002 to .0003 thick, Class 3, Type I, per QQ-P-416.

Cad plate .0002 to .0003 thick, and bonderize. Class 3, Type III, per QQ-P-416.

Cad plate .0002 to .0003 thick, and parkerize. Class 3, Type III, per QQ-P-416.

Cad plate .0003 to .0004 thick, Class 2, Type I, per QQ-P-416.

Cad plate .0005 thick, per QQ-P-416, Class 1, Type I.
706  Cad plate .0005 thick, and bonderize per QQ-P-416, Class 1, Type III.
707  Cad plate .0005 thick, and parkerize per QQ-P-416, Class 1, Type III.
708  Cad plate .0005 thick, and Golden Dichromate Dip per QQ-P-416, Class 1, Type II.
709  Cad plate .0005 thick, and Iridite #8P per QQ-P-416, Class 1, Type II.
710  Identical to 708.
711  Identical to 708.
712  Cad plate .0003 min. and Golden Dichromate Dip per QQ-P-416, Class 2, Type II.
713  Identical to 708.
714  Cadmium plate .0002 to .0003 thick, per QQ-P-416, Type II, Class 3 (Iridite Black).
715  Cadmium plate .0005 thick per QQ-P-416, Type II, Class 1 and Black Iridite.
716  Cadmium plate .0015 to .0020 thick.
717  Electrofilm No. 4396, solid film lubricant over cadmium plate per QQ-P-416, Class 2, Type II.
718  Cadmium plate .0005 thick per QQ-P-416, Type II, Class 1 and Olive Drab Iridite #1.
719  Cadmium plate .0002 to .0003 thick and chromate dip per QQ-P-416, Class 3, Type II.
720  Cadmium plate .0002 to .0003 thick, per QQ-P-416, Class 3, bonderize one coat zinc chromate primer, two coats dark gray enamel per Navy Spec. 52E4, Type III (Munsell 4.5).
721  Cadmium plate .0002 to .0003 thick and olive drab iridite per QQ-P-416, Class 3, Type II.
722  Cadmium plate .0002 to .0003 thick per QQ-P-416, Class 3, bonderize one coat zinc chromate primer, two coats dark gray enamel per Navy Spec. 52E4, Type III, 10° maximum gloss.
Cadmium plate .0002 to .0003 thick per QQ-P-416, Class 3. Bonderize one coat zinc chromate primer, two coats dark gray enamel per Navy Spec. 52E4, Type III, 35° minimum gloss.

Cadmium plate .0005, per QQ-P-416, Class 1. Bonderize one coat zinc chromate primer, two coats dark gray enamel per Navy Spec. 52E4, Type III, 35° minimum gloss.

Cadmium plate .0003 min. and Iridite #8 per QQ-P-416, Class 2, Type II.

Anodize per MIL-A-8625, Type II and gray dye.

Cadmium plate .0005 thick per QQ-P-416, Class 1. Bonderize one coat clear metal primer, and two coats machinery gray baking enamel per Raytheon Spec. L44-5837.

Cadmium plate .0002 to .0003 thick per QQ-P-416, Class 3, bonderize one coat black paladin primer, fine black wrinkle per MIL-E-5558, Type I.

Identical to 728, except masking or other qualifications as per drawing.

Cadmium plate .0005 thick per QQ-P-416, Class 1. Bonderize one coat zinc chromate primer per MIL-P-6889, and two coats light gray air drying semi-gloss enamel per MIL-E-15090, Type I, Class 2.

Cadmium plate .0002 to .0003 thick per QQ-P-416, Class 3. Bonderize one coat zinc chromate primer, two coats light gray air drying semi-gloss enamel per MIL-E-15090, Type II, Class 2. (Primer per MIL-P-6889).

Cadmium plate .0002 to .0003 thick per QQ-416, Class 3. Bonderize one coat zinc chromate, and two coats of light gray baking enamel per MIL-E-15090, Class 2, Type III. (Primer per MIL-P-6889).

Cadmium plate .0002 to .0003 thick per QQ-P-416, Class 3. Bonderize one coat zinc chromate primer, and paint per Federal Spec. TT-C-595, #2610 (similar to machinery gray).

Cadmium plate .0003 thick per QQ-P-416, Class 2, chromate dip, one coat zinc chromate primer, per MIL-P-6889, and two coats semi-gloss light gray baking enamel per Spec. MIL-E-15090, Type III, Class 2.
Identical to #732, except masking or other qualifications as per drawing.

Cadmium plate .0005 thick and chromate per QQ-P-416, Class 1, Type II. Chromate treatment shall be of short duration (approximately five (5) seconds), such that a bright silvery cadmium surface is produced with no visible iridescent yellow coloration.

Cadmium plate .0002 to .0003 thick per QQ-P-416, Class 3, and bonderize one coat clear metal primer, two coats machinery gray lusterless baking enamel, Raytheon Spec. L44-5835.

Cadmium plate .0005 thick and chromate dip per QQ-P-416, Type II, Class 1, zinc chromate primer per Spec. JAN-P-735. Paint light gray baking enamel per MIL-E-15090, Formula 3, Class 2, Type II.

Cadmium plate .0005 thick per QQ-P-416, Class 1, Type I, one coat of clear lacquer.

Cadmium plate .0002 to .0003 thick, and bonderize per QQ-P-416, Type III, Class 3. One coat black palladin primer. One coat lusterless black synthetic enamel, Grade I per Spec. 3-173. Masking required as per drawing.

Cadmium plate .0005 thick per QQ-P-416, Class 1, and bonderize one coat black palladin primer, one coat black wrinkle enamel, Hazeltine Spec. S-195-D.

Cadmium plate .0005 min. thick, and iridite per QQ-P-416, Class 1, Type II. One coat zinc chromate primer per MIL-P-8585; two coats gray semi-gloss enamel, Grade I per 3-174, Color TT-C-595, Shade 2610.

Cadmium plate .0002 to .0003 thick per QQ-P-416, Class 3, bonderize one coat of zinc chromate primer, and paint olive drab per MIL-E-11237. Color per TT-C-595, #3412. Masking required as per drawing.

Cadmium plate .0003 thick min., and Iridite #8 per QQ-P-416, Type II, Class 2. One coat zinc chromate primer per MIL-P-6889, two coats black semi-gloss baking enamel.

Cadmium plate .0005 thick per QQ-P-416, Class 1, bonderize per JAN-C-490, Grade I. One coat synthetic paint primer per TT-P-636. Paint semi-gloss enamel per MIL-E-11857, Class B. Color to be per Federal Spec. TT-C-595, Shade #2610.
Cadmium plate .0002 to .0003 thick per QQ-P-416, Type II, Class 3, and olive drab Iridite #1.

Identical to Suffix #743, except no masking required.

Cadmium plate .0002 to .0003 thick per QQ-P-416, Class 3, bonderize one coat of RCA #430 satin black synthetic. One coat RCA #412, Maring Corps. lusterless green enamel.

Cadmium plate .0002 to .0003 thick per QQ-P-416, Class 3, bonderize zinc chromate primer per AN-P-656. Paint per Spec. 3-174, olive drab semi-gloss enamel, Color 2430 per Spec. TT-C-595. Masking per drawing.

Cadmium plate .0003 thick per QQ-P-416, Class 2, bonderize one coat RCA #430, satin black synthetic. One coat RCA 838, olive drab, lusterless baked enamel.

Cadmium plate .0002 to .0003 per QQ-P-416, Class 3, bonderize one coat zinc chromate primer, two coats lusterless olive drab enamel, Color #319 per USA Spec. 3-1.

Cadmium plate .0002 to .0003 thick per QQ-P-416, Class 3, bonderize one coat zinc chromate primer, two coats smokey gray baking enamel, per Spec. 52E4 (Munsell 4.5).

Cadmium plate .0002 to .0003 thick, and bonderize per QQ-P-416, Class 3, Type III, and paint with dull black air drying enamel.

Cadmium plate and bonderize per QQ-P-416, Type III, Class 2, zinc chromate primer per MIL-P-6889, Type I or II; two coats semi-gloss non-wrinkle gray enamel, Color No. 2610 of TT-C-595, per MIL-E-11857, (Ord.) Class B.

Cadmium plate .0003 min. thick, and Iridite #8, hue bright per QQ-P-416, Type II, Class 2. One coat zinc chromate primer per MIL-P-6889. Finish with olive drab baking enamel per TT-E-485, Type IV, color per TT-C-595, No. 1405, Gloss 4° to 12° (60° incidence).

Identical to Finish #755, except masking required as per drawing.

REVA Cadmium plate .0003 min. thick, and Iridite #8, hue bright per QQ-P-416, Type II, Class 2. One coat zinc chromate primer per MIL-P-6889, plus two coats olive drab semi-gloss baking enamel per TT-E-529, Class B, Color No. 24084. (Government approved vendor for plating must be used). (Certificate of compliance on paint specifications listed required on each order).
758 Cadmium plate .0005 min. thick per QQ-P-416, Class 1, Type II and olive drab iridite per Air Associates Spec. #PS1007 (per Color Chip #RS-146).

759 Cadmium plate .0002 thick per QQ-P-416, Class 3, Type II and olive drab iridite per Air Associates Spec. #PS1007 (per Color Chip #RS-146).

760 Cadmium plate .0005 thick and chromate dip per QQ-P-416, Class 1, Type II. One coat zinc chromate primer per MIL-P-6889, and two coats semi-gloss, light gray baking enamel per Spec. MIL-E-15090, Type III, Class 2.

761 Cadmium plate .0005 thick, and golden dichromate dip per QQ-P-416, Class 1, Type II, and one coat darkened zinc chromate primer per MIL-P-6889, Type I, Color No. 611.

762 Identical to 761, except masking required as per drawing.

763 Cadmium plate .0005 thick per QQ-P-416, Type I, Class 1. Prime with one coat of wash pretreatment per Spec. MIL-C-15328 applied as a continuous film; .002 to .005 inch thick; paint two coats light gray baking enamel, semi-gloss formula No. 111 per MIL-E-15090.

764 Cadmium plate .0002 thick per QQ-P-416, Class 3, Type I, and one coat of primer per MIL-C-15328, and two coats of baked gray enamel per MIL-E-15090, Class 2.

765 Identical to 733, except masking or other qualifications required as per drawing.

766 Cadmium plate .0005 thick and chromate dip per QQ-P-416, Class 1, Type II. One coat zinc chromate primer per MIL-P-6889, and two coats semi-gloss light gray baking enamel per MIL-E-15090. Type III, Class 2, Color 26307 per TT-C-595.

767 Cadmium plate .0005 thick and chromate dip per QQ-P-416, Class 1, Type II, one coat zinc chromate primer per MIL-P-6889 and one coat of semi-gloss enamel, minimum film thickness .001; Color Green No. 2430 per TT-C-595; Masking or other requirements as per drawing.

768 Cadmium plate .0003 min. thick and Iridite #8, hue bright per QQ-P-416, Type II, Class 2. One coat zinc chromate primer per MIL-P-6889, plus two coats of olive drab lusterless baking enamel per TT-E-527, Color No. 34087 per FED-STD-595.
Cadmium plate and chromate dip per Teletype Corp. Manufacturing Process Specification Nos. 10069 and 10032.

Identical to 708, except for masking or other specs. as per drawing.

Identical to #708, with the additional provision that plated parts are to be free of all scratches and blemishes. Vendor will wrap all parts in Kraft Paper. Parts are to be inspected before and after sending cut to vendor for abovementioned defects.

Cadmium plate per QQ-P-416, Class 1, Type I. Prime zinc chromate MIL-P-8585. Yellow color (1) coat per MIL-P-6808. Enamel equipment light gray, Type III, Class 2, MIL-E-15090 (2) coats. Tapped holes to be free of paint.

**MISCELLANEOUS FINISHES**

Obsolete IBM blue (A167), baked enamel (Wright Line Paint No. 001655).

REVA Chemical film per MIL-DTL-5541, Class 1A, zinc chromate primer per MIL-P-6889, lusterless gray paint, Color No. 36231 per Fed. Std. 595.

Passivate per MIL-F-14027-E300, black paladin primer per G. E. F32-GP9 and light gray enamel per MIL-E-15090, Class 2, Gloss 20-35, Type II or Type III.

Passivate per MIL-F-14027-E300, black paladin primer per G. E. F32-GP9, and light gray enamel per MIL-E-15090, Class 2, Gloss 20-35, Type II. Masking required as per drawing.

Chemical Film MIL-DTL-5541, Class 1A. Prime w/zinc chromate primer per MIL-P-6889. Paint 2 coats light gray enamel. (MIL-E-15090, Class 2) Color Chip No. 26440 per Fed. Std. 595.

Iridite 14-4 per MIL-DTL-5541.

One coat pretreatment primer per MIL-P-15328. One coat primer per MIL-P-8585, Color Y, 2 coats gray enamel per MIL-E-15090, Type III, Class 2.

Apply yellow chromate conversion coating per MIL-DTL-5541, Class 1A. Clean in a solvent or vapor type degreaser before applying primer. Spray one coat of zinc chromate primer conforming to MIL-P-8585. Spray one coat of semi-gloss gray baking enamel, Fed. Spec. TT-E-529, Class B, Color No. 26173 (Fed. Std. 595) Raffi & Swanson No. 5935, Thinner No. 4047 (or equivalent). Bake three (3) hours at 100° C.
781  Identical to 780, except for masking or other spec. as per drawing.

782  Spray one coat of zinc chromate primer conforming to MIL-P-8585. Spray one coat of semi-gloss gray baking enamel, Fed. Spec. TT-E-529, Class B, Color No. 26173 (Fed. Std. 595) Raffi & Swanson No. 5935, Thinner No. 4047 (or equivalent). Bake three (3) hours at 100° C; masking or other specifications as per drawing.

783  Cadmium plate .0003 min. thick, and Iridite No. 8, hue bright per QQ-P-416, Type II, Class 2. One coat zinc chromate primer per MIL-P-8585, plus two coats black semi-gloss air dry enamel per TT-E-529, Class A, Color No. 27038. (Vendor must have approval from Government Agency for this process).

784  Cadmium plate .0005 thick, and golden dichromate dip per QQ-P-416, Class 1, Type II. One coat of vinyl resin-zinc chromate primer per Raytheon Spec. No. S223-1112G1, consisting of two (2) parts of S223-1112P5 and one (1) part catalyst, S223-1114P5 and reducer S223-1113P5 as required. One coat of zinc chromate primer, Type I, per MIL-P-8585. Two coats gray paint, semi-gloss, air dry per Raytheon Spec. S223-1223P5. Reference: Raytheon Finish Spec. No. YA388-10016A.

785  Identical to 784, except for masking as per drawing.

786  Phosphoric-acid etch per MIL-C-10578, one coat zinc chromate primer 0.4 to 0.6 mil. (dry film) thick, per MIL-P-8585, one coat semi-gloss gray enamel per TT-E-529, Color No. 2610 per TT-C-595.

787  Cadmium plate - see Barry Data Sheet No. 744.

788  Hot dip galvanize .008 -.010 thick. Additional requirements as per drawing.

789  Phosphate per TT-C-490, Grade III (Turcoat Paintite) or equal lacquer primer per Western Electric Spec. 2152.100 gray lacquer finish per Western Electric Spec. 2043.100.

790  Black paint per Barry Data Sheet 748. Masking or other requirements as per drawing.

791  Passivate copper brazed stainless steel with controls necessary to avoid attacking braze.
Process for blackening stainless steel - see Barry Data Sheet No. 753. (Kollsman Spec. KPS-5B.1000a).

See Barry Data Sheet No. 754 for procurement and application instructions.

Cadmium plate .0005 thick and chromate dip per QQ-P-416, Type II, Class 1. One coat zinc chromate primer per MIL-P-6889. Two coats light gray fast air drying enamel, Type II, Class 2 per MIL-E-15090.

Cadmium plate .0003 min. and golden dichromate dip per QQ-P-416, Class 2, Type II. Finish P371Y (forest green (CARC) lusterless gloss, .0018 min. thickness per Spec. MIL-C-46168 per Spec. MIL-F-14072, except primer, Step 3, which shall be an epoxy polyamide, chemical and solvent resistant coating per Spec. MIL-P-23377. Masking required as per drawing.

Phosphate treat per TT-C-490, Grade 1 (bonderite or equivalent); prime with zinc chromate per latest version of MIL-P-6889; paint one coat green semi-gloss enamel per TT-E-529, Color No. X-24084 per Fed. Std. 595.

Zinc plate .0005 min. and bonderize per ASTM B633, FE/ZN12, Type III. One coat zinc chromate primer per MIL-P-6889; two coats light gray baking enamel per MIL-E-15090, Class 2, Type III, except glossrange to be 20 to 35. (Hazeltine to supply paint including primer).

Iridite 14-2 and lusterless black - see Barry Data Sheet 759. (Midwestern Instrument Spec. 95B443) masking as per drawing.

1. Clean; 2. Passivate with chemical film per MIL-DTL-5541; 3. Prime with one coat of zinc chromate primer, 0.4 to 0.6 mil. (dry film) thick per MIL-P-6889, or apply pretreatment coating, 0.2 to 0.3 mil. (dry film) thick, per MIL-C-15328 followed by primer specified above; 4. Final paint coat shall be Color No. 34087 in accordance with FED-STD-595.

(Olive Drab)
### ZINC PLATING WITH FINISH VARIATIONS

<table>
<thead>
<tr>
<th>Code</th>
<th>Description</th>
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</thead>
<tbody>
<tr>
<td>800</td>
<td><strong>REVA</strong> Chemical film per <em>MIL-DTL-5541</em>, Class 1A, including amendment 1, plus *MIL-P-8585 zinc chromate primer, Color Y, applied per *MIL-P-6808 to a nominal thickness of .004. *Certification required.</td>
</tr>
<tr>
<td>801</td>
<td>Zinc plate .0002 to .0003 thick per ASTM B633, Class FE/ZN 5, Type III.</td>
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<tr>
<td>802</td>
<td>Zinc plate .0002 to .0003 thick per ASTM B633, Class FE/ZN 5, Type IV.</td>
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<tr>
<td>803</td>
<td>Identical to 802.</td>
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<tr>
<td>804</td>
<td><strong>REVA</strong> Zinc plate .0003 to .0004 thick per ASTM B633, Class FE/ZN 8, Type III.</td>
</tr>
<tr>
<td>805</td>
<td><strong>REVB</strong> Bright zinc plate per ASTM B633, Class FE/ZN 12, Type III.</td>
</tr>
<tr>
<td>806</td>
<td><strong>REVA</strong> Zinc plate per ASTM B633, Class FE/ZN 12, Type IV.</td>
</tr>
<tr>
<td>807</td>
<td>Identical to 806.</td>
</tr>
<tr>
<td>808</td>
<td><strong>REVA</strong> Zinc plate and golden dichromate dip per ASTM B633, Class FE/ZN 12, Type II.</td>
</tr>
<tr>
<td>809</td>
<td><strong>REVC</strong> Zinc plate .0005 thick per ASTM B633, Class FE/ZN12, Type I, and luster on dip and leach.</td>
</tr>
<tr>
<td>810</td>
<td>Identical to 808.</td>
</tr>
<tr>
<td>811</td>
<td>Identical to 808.</td>
</tr>
<tr>
<td>812</td>
<td><strong>REVC</strong> Zinc plate .0005 thick per ASTM B633, Class FE/ZN12, Type I, and black phosphate and dip in drying oil.</td>
</tr>
<tr>
<td>813</td>
<td>Zinc plate per ASTM B633, Class FE/ZN 25, Type IV.</td>
</tr>
<tr>
<td>814</td>
<td>Zinc plate .0002 to .0003 thick per ASTM B633, Class FE/ZN5, Type IV, phosphate dip impregnate with black resin.</td>
</tr>
<tr>
<td>815</td>
<td><strong>REVB</strong> Bright zinc plate .0002 to .0003 thick per ASTM B633, Class FE/ZN5, Type I. Within two hours after plating, bake at 275° to 375° F for three hours to relieve embrittlement.</td>
</tr>
</tbody>
</table>
| 816  | **REVC** Chemical Film per MIL-DTL-5541, Class 1A. One coat zinc chromate primer per MIL-P-6889 (superseded by MIL-P-8585 which is superseded by TT-P-1757), and cover coat with aircraft
lacquer gray; (2 coats) painting to conform to TT-L-32 (superseded by A-A-3165). Masking required as per drawing. Color to be No. 16473 per FED-STD-595.

817 Zinc plate .0002 to .0003 thick, and golden dichromate dip per ASTM B633, Class FE/ZN 5, Type II.

818 Identical to 808.

819 Phosphate per TT-C-490, Grade I. One coat zinc chromate primer .0004 to .0006 thick per MIL-P-8585. Apply two coats of gray enamel to each layer, approximately .001 thick per MIL-E-15090, Type III, Class 1.

820 REV B Zinc plate .0002 to .0003 thick per ASTM B633, Class FE/ZN5, Type I. Bonderize one coat zinc chromate primer, two coats dark gray baking enamel per Navy Spec. 52E4, Type C (MUNSELL 4.5).

821 Identical to 827, except masking or other qualifications as per drawing.

822 REV B Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize, one coat chromate primer, two coats dark gray enamel per Navy Specification 52E4, 10° maximum gloss.

823 REV B Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer, two coats dark gray enamel per Navy Specification 52E4, 35° minimum gloss.

824 REV B Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat of baked zinc chromate, and two coats of gray paint per G. E. Specification F31-GP17.

825 Cancelled - USE 832.

826 REV C Zinc plate .0005 thick per ASTM B633, FE/ZN12, Type I. Bonderize one coat zinc chromate primer, one coat dark gray baking enamel, per Specification 52E4, Type C, minimum gloss 35°.

827 REV C Zinc plate .0005 thick per ASTM B633, FE/ZN12, Type I. Bonderize one coat clear metal primer, and two coats machinery gray baking enamel per Raytheon Specification L44-5837.
Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat clear primer, and two coats machinery gray baking enamel (Munsell 4.5, 35° gloss) Raytheon Specification ZA-296-1048.

Zinc plate, phosphate and paint per the following Bell Telephone Lab., Inc., Specification: Zinc plate 0.0002 inch thick (minimum 23 MSI) per No. 563 (ESA-640030); phosphate per No. 564 (ESA-640031) and paint federal gray enamel per No. 3008JR. (ESA-635014).

Zinc plate .0005 thick per ASTM B633, FE/ZN5, Type I. Chromate dip one coat zinc chromate primer per MIL-P-6889, and two coats light gray air drying semi-gloss enamel per MIL-E-15090, Type I, Class 2.

Zinc plate per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer; two coats light gray semi-gloss air drying enamel per MIL-E-15090, Type II, Class 2. (Primer per MIL-P-6889).

Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5 Type I, followed by zinc phosphate per TT-C-490 Type I, followed by one coat zinc chromate primer per MIL-P-6889, and two coats light gray baking enamel, per MIL-E-15090, Type III, Class 2.

Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat clear primer, two coats light gray air drying enamel (35° gloss) Raytheon Spec. ZA-296-1121).

Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. One coat zinc chromate primer, one coat OSTD #52, Paint #37 neutral gray (Arma).

Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer, one coat OSTD #52, Paint #7 (neutral gray) with inhibiting agents added (Arma).

Zinc plate .0005 thick per ASTM B633, FE/ZN12, Type I. Bonderize one coat RCA #430 satin black synthetic, one coat RCA #862 smokey gray baking enamel, (RCA #863 finish).

Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat of clear metal primer and two full wet coats machinery gray lusterless baking enamel, per Raytheon Spec. L44-5835.

Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat of brown primer. Paint with machinery gray baking enamel, Munsell 4.5 35° gloss, per Raytheon Spec. YA 296-1048.

Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat gray paladin primer, gray wrinkle enamel.
840 REVB  Zinc plate .0003 thick per ASTM B633, FE/ZN8, Type I. Bonderize two coats RCA #430 satin black synthetic (one coat for primer, one coat for finish).

841 REVC  Zinc plate .0005 thick per ASTM B633, FE/ZN12, Type I. Bonderize one coat black paladin primer, one coat black wrinkle enamel, Hazeltine Spec. S-195-D.

842 REVB  Zinc plate, .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat clear metal primer, 2 coats dull black instrument baking enamel per Spec. MIL-E-5557, Type IV.

843 REVC  Zinc plate .0005 thick per ASTM B633, FE/ZN12, Type I. Bonderize one coat zinc chromate primer, and two coats light gray baking enamel per MIL-E-15090, Class 2, Type III.

844 REVB  Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer, two coats light gray enamel per Navy Spec. 52-E-4, Type IV.

845 REVB  Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer. Paint lusterless synthetic enamel per MIL-E-11237, Color 3412 per Federal Spec. TT-C-595.

846 REVB  Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer and two coats medium gray enamel per Bell Tel. Spec. OD-7403.

847 REVB  Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer per JAN-P-735, two coats medium gray air drying enamel per Federal Spec. TT-C-595, Color No. 2615.

848 REVB  Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer and two coats of light gray baking enamel (supplied by Hazeltine, their Spec. S257-2).

849 REVB  Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize zinc chromate primer per AN-P-656, paint per Spec. 3-174 olive drab semi-gloss enamel; Color 2430 per Spec. TT-C-595.

850  Zinc plate .0002 to .0003 thick per ASTM B633, Class FE/ZN 5, Type IV. Prime by spraying one (1) coat of R.C.A. #2016114-1 satin black synthetic per R.C.A. Finish Spec. #1908430. Spray two (2) coats of olive drab lusterless enamel per TT-E-527, Color No. 3412 per R.C.A. standardizing notice 98-2-838. (See copies of the following Spec. 1980948, (3) R.C.A. standardizing notice 98-2-838, (4) R.C.A. approval source notice 100-6-948).
851 REVB  Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer, two coats lusterless olive drab enamel, Color #319 per USA Spec. 3-1.

852 REVC  Zinc plate .0005 thick per ASTM B633, FE/ZN12, Type I. Bonderize one coat zinc chromate primer per Fed. Spec. TT-P-636. Two coats semi-gloss olive drab enamel per USA Spec. 3-174, Grade 1, Color #2430 per Fed. Spec. TT-C-595.

853 REVB  Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer per G.E. Spec. 7710, and two coats G.E. 7496 (blue-gray melamine Glyptal) sprayed and air dried.

854 REVB  Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer per MIL-P-6889, finish with black semi-gloss enamel, Grade 1 per Spec. 3-174, Color #2710 per Spec. TT-C-595.

855 REVB  Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer, two coats blue semi-gloss baking enamel per Consolidated Eng. Corp., Spec. 24829-941. (May be purchased from Bradley Paint Co., Los Angeles, California). Masking required as per drawing.

856 REVB  Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer per G.E. Spec. 7710, and two coats G.E. 8012 (blue-gray finish). Both primer and finish should be reduced using G.E. #1500 thinner to 14-17 seconds using a #3 Zahn Viscosemometer (or equal).

857  Zinc plate .0002 to .0003 thick per ASTM B633, Class FE/ZN 5, Type IV. 1 coat zinc chromate primer, ALKYD type air dried per JAN-B-735. Two (2) coats light gray enamel per MIL-E-15090, Type I, Class 2 (air dried).

858  Identical to 857, except masking or other qualifications as per drawing.

859  Zinc plate .0002 to .0003 thick per ASTM B633, Class FE/ZN 5, Type I. Brown metal primer and medium gray baking enamel per Western Electric Spec. No. 3025JR, and Western Electric Drawing ESA-641403.
860 REV B Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer, two coats insignia red baking enamel, Color #509 per ANA Bulletin #166.

861 REVA Zinc plate and golden dichromate dip per ASTM B633, Class FE/ZN 12, Type II. One coat zinc chromate primer per MIL-P-6889, two coats light gray baking enamel per MIL-P-15090, Class 2, Type III.

862 REVA Zinc plate per ASTM B633, Class FE/ZN 12, Type IV. One coat zinc chromate primer per MIL-P-6889, two coats light gray baking enamel per MIL-15090, Type III, Class 2, except gloss range to be 20 to 35.

863 REV B Zinc plate .0002 to .0003 thick per ASTM B633, FE/ZN5, Type I. Bonderize one coat zinc chromate primer and two coats gray baking enamel, Formula No. 13811, Lot No. 62657. (Purchase from A.C. Buschman & Co., Newark, New Jersey).

864 REVA Zinc plate per ASTM B633, Class FE/ZN 12, Type II or Type III. Two coats of paint per MIL-E-15090, Type II, Class 2, Color 26357 per TT-C-595.

865 REVA Zinc plate per ASTM B633, Class FE/ZN 12, Type IV. Primer per TT-P-636, plus 2 coats olive drab baked enamel per TT-E-529, Color #2430 per TT-C-595.

MISCELLANEOUS FINISHES

866 Passivate per Barry Data Sheet #692.

867 Passivate per Barry Data Sheet #693.

868 Bright alloy plate as per Barry Data Sheet #689.

869 Chemical polish as per Barry Data Sheet #690.

870 REV B Phosphate treat per TT-C-490, Type I or grit blast. Prime with zinc chromate primer per TT-P-1757, Color Y, and finish with olive drab enamel, Color No. 24084 per TT-C-595. Masking or other specifications as per drawing.
871 Phosphate treat per TT-C-490, Type I or grit blast. Prime with zinc chromate primer per TT-P-1757, Color Y, and finish with light gray enamel per MIL-E-15090, Type II, Class 2 (2 coats of enamel), Color No. 26307 per FED-STD-595.

872 REVA Anodize and apply instrument black enamel per MIL-E-5557, Type IV (baking), Color No. 37038 per Federal Spec. TT-C-595. Apply per Barry Data Sheet #660. Masking or other specifications per drawing.

873 Prime and finish Marine Corps., Green, Color No. 23 (semi-gloss) in accordance with MIL-T-704, Type A and TT-E-485, Type II.

874 Caustic etch, one coat zinc chromate primer per MIL-P-8585, Type II, fine black wrinkle per MIL-E-5558, Type I (use toluene thinner per Federal Specification TT-T-548), mask as per drawing. Maximum baking temperature not to exceed 250°F.

875 Phosphate coat per OD-7401, one coat zinc chromate primer (alkyd type) air dried JAN-P-735; two coats light gray air drying enamel, per MIL-E-15090, Class 2, Type I.

876 One coat zinc chromate primer (alkyd type) baked JAN-P-735; two coats light gray enamel per MIL-E-10090, Class 2, Type III.

877 One coat zinc chromate primer; one covering coat light gray machine enamel.

878 Clear sulfuric anodize per MIL-A-8625, Type II, and strontium chromate prime per Barry Data Sheet No. 581.

879 Prime per MIL-C-15328, two coats baked gray enamel per MIL-E-15090, Class 1. See drawing for masking requirements.

880 Light green baking enamel per Barry Data Sheets 588 and 589.

881 Identical to 875, except masking or other qualifications as per drawing.

882 Prime with MIL-P-6889, Type I, zinc chromate primer per MIL-P-6808.

883 Phosphate coat per OD-7401, plus zinc chromate primer and light gray enamel per Western Electric Drawing #MPS-91876, and color chip referenced therein.
884 Identical to 883, except masking or other qualifications as per drawing.

885 Cloth wheel, buff surfaces designated on drawing, and passivate all over.

886 Light vapor blast and passivate.

887 Gray endurion.


889 Prime all over with one coat zinc chromate primer per MIL-P-6889, Type I, bake for 1/2 hour at 250°F. Finish all over with one coat dull black enamel (thinned for spraying). Bake for 3 hours at 300°F.

890 Electroplate 60-40 solder - .0005 minimum thickness.

891 REVA Caustic dip per Barry Finish 909 - satin finish and water dip lacquer.

892 Alodine 600 process, per MIL-DTL-5541.

893 One coat zinc chromate primer, one coat bright red machine enamel.

894 One coat zinc chromate primer, one coat dark gray machine enamel. See drawing for masking requirements.

895 REVA Caustic dip per Barry Finish 909 - one coat of zinc chromate primer; one coat dark gray machine enamel.

896 One coat dark gray machine enamel.

897 Green strontium chromate, epoxy base primer. See Barry Data Sheet #635.

898 Same as Suffix 897, except masking or other qualifications as per drawing.

899 Alodine 1000 per MIL-DTL-5541 (colorless).
PASSIVATED FINISHES

900  Zinc phosphate, Type I per TT-C-490.

901  C  Passivate per ASTM A967 or SAE AMS2700 (QQ-P-35 has been superceded).

902  Black passivate, Type I, no post-treatment dip*, Type II, dip in oil, and wipe to remove excess. *(To be used unless otherwise specified). Finish No. 902 has been superseded by Finish Nos. 9087 and 9088.

903  Passivate and black wrinkle.

904  Electropolish and passivate.

905  Passivate and apply zinc chromate primer per MIL-P-6889 on surfaces specified on drawing.

906  Passivate and apply zinc chromate primer per MIL-P-6889 all over.

OXIDE FINISHES

907  Black oxide per MIL-C-13924, Class 2. (With supplementary preservative treatment). Wipe and remove excess preservative.

908  Black oxide on unplated steel.

CAUSTIC FINISHES

909  REVB Colorless Chemical Conversion Coat Per MIL-DTL-5541, Class 1A. Use BDS 1749 when performing Caustic Etch within Barry Controls.

910  REVA Caustic dip identical to Barry Finish 909.

911  REVA Caustic dip per Barry Finish 909, dip in thin lacquer (20 parts thinner to 1 part clear lacquer).

912  REVA Caustic dip per Barry Finish 909, black paladin primer, black wrinkle.

913  Nickel plate per Navy Spec. MIL-P-6859, and black ebonol, Type I, Class A. (.0005" thick plating).
914 REVA  Caustic dip per Barry Finish 909, gray paladin primer, gray wrinkle enamel.

915 REVA  Caustic etch per Barry Finish 909, zinc chromate primer per Spec. MIL-P-6889, Type II, black wrinkle per Spec. MIL-E-5558, Type II.

916 REVA  Caustic etch per Barry Finish 909, one coat of zinc chromate primer per Spec. MIL-P-6889, and one coat of flat black lacquer.

917  Identical to 916, except masking or other qualifications as per drawing.

918 REVA  Caustic dip per Barry Finish 909, and apply zinc chromate primer per MIL-P-6889 on surfaces specified on drawing.

919 Clean and degrease thoroughly. One coat of wash pretreatment per MIL-P-15328 applied as a continuous film 0.0002” to 0.0003” thick. One coat zinc chromate primer per MIL-P-8585. Two coats gray enamel per MIL-E-15090, Class 2, Type III, each coat .001” thick.

920 REVA  Aluminum conversion coating per MIL-DTL-5541, Class 1A (color per drawing and applicable color chips). Color to be yellow unless otherwise specified.

921 Iridite #14 (Alcote) and green dye.

922 Iridite frosted finish on aluminum alloy.

923 Identical to 911, except masking required as per drawing.

924 Iridite #14-2 per Air Associates, Spec. RS404, per color chip supplied by Production Engineering.

925 Iridite #14 (Alcote). Cover with black palladin primer, fine black wrinkle per MIL-E-5558, Type I. Apply per MIL-E-7851.

926 Identical to 927, except less masking.

927 Caustic etch, one coat zinc chromate primer per MIL-P-6889. Olive green lusterless enamel per MIL-E-11237, mask as per drawing.

928 Dichromate per MIL-M-3171, Type III, (Dow No. 7) with masking required as per drawing.

929 Dichromate per MIL-M-3171, Type III, (Dow No. 7).
SILVER PLATED FINISHES

930 Silver plate .0002 to .0004 thick.

931 Silver plate .0002 to .0004 thick and water dip lacquer, per Collins Spec. 580-0022 00, (per U. S. Army Spec. 72-53, Par. 3-E).

932 Silver plate .0005 minimum thickness, per QQ-S-365, Type I, Grade B.

933 Silver plate .0005 to .00075 thick, and dip in water, dip lacquer per G.E. Spec. F, 45GPL.

934 FLASH silver plate.

935 Dull silver plate 0.0005 to .00075 per G.E. Spec. F70H2C.

936 Silver plate .0002 to .0004, and water dip lacquer per Navy Spec. 46-P-5, Type 1, Class 2.

937 Bright silver plate per QQ-S-365, Type III, Grade A (.0005 min. thick).

938 Bright silver plate per QQ-S-365, Type III, .0005 thick.

NICKEL PLATED FINISHES

939 Nickel plate .0005 min. thickness per MIL-P-6395, Type I, Class B.

940 REV B Nickel plate per QQ-N-290, Class 1, Grade G, (thickness per Table I).

941 Copper plate .0002 to .0003 and black oxidize.

942 Black nickel plate .0002 to .0003 thick.

943 REV B Nickel plate per QQ-N-290, Class 1, Grade E, (thickness per Table I).

944 REV C Nickel plate per QQ-N-290, Class 1, Grade F, (thickness per Table I).

945 Chromium plate per AN-P-39, Class A, Type I, (0.00002 min.).

946 .0005 thru .0006 copper plate; .0004 to .0005 nickel plate; flash chrome. Minimum build-up .001, maximum build-up .002.
**MISCELLANEOUS FINISHES**

947 Passivate, one coat black paladin primer, two coats dull black baking enamel per MIL-E-11237. Masking required as per drawing.

948 Phosphate coat per U.S. Army Spec. 57-0-2C, Type II, Class C. One coat zinc chromate primer per MIL-P-6889. One coat dark gray enamel per U.S. Navy Specification 52E4, Type C, 35° min. gloss.

949 REVA Chromate conversion coat per MIL-DTL-5541, Class 1A. One coat zinc chromate primer .0004 to .0006 thick per MIL-P-8585. Apply two coats gray enamel, each layer approximately .001 thick per MIL-E-15090, Type III, Class I. Mask as required per drawing.

950 Dull black air drying enamel.

951 Zinc chromate primer per Spec. MIL-P-6889, one coat lusterless air drying olive drab enamel.

952 Semi-gloss, machinery gray, air drying enamel per Spec. TT-C-595, Shade 72-53, Table 1, Type I.

953 Black palladin primer, fine black wrinkle, per MIL-E-5558, Type I, apply per MIL-E-7851.

954 Zinc chromate primer, one coat dull black baking enamel.

955 Zinc chromate primer, per Spec. MIL-P-8585.

956 Zinc chromate primer per Spec. MIL-P-8585, two coats dull black baking enamel.

957 One coat zinc chromate primer per Spec. MIL-P-6889, and two coats dull black enamel, Munsell N 1.5, Gloss 2-8.

958 Zinc chromate primer per Spec. MIL-P-8585, Type II, black wrinkle per Spec. MIL-E-5558, Type II.

959 Gray palladin primer, gray wrinkle.

960 REVA Hot tin dip, .0002 minimum thickness, per MIL-T-10727, Type II. **MIL-T-10727 has been deemed obsolete. Please refer to ASTM B 339.**

961 Galvanized.

962 Tin plate per Spec. MIL-T-10727 (ord.), Type I - .0003" minimum thickness.

963 One coat moisture resistant varnish.

964 One coat clear flat lacquer.
965 Two coats clear spar varnish.

966 Phosphate coat.

967 Phosphate coat per U. S. Army Spec. 57-0-2C, Type II, Class C, finish with dark gray enamel per U. S. Navy Spec. 52E4, Type C, 35° min. gloss.

968 Phosphate coat, one coat black palladin primer, one coat black rubber base gloss paint.

969 Black Japan.

970 Dow #1 chemical treatment.

971 Dip in Oakite #36, and rinse in hot water (per G. E. Spec., P-4-GP2, Part IV) (for alloys of less than 1% copper).

972 Dip in Oakite #36, and rinse in cold running water (per G. E. Spec., P4-GP2, Part V) (for alloys of more than 1% copper).


974 Alodine 1200 process per MIL-DTL-5541.

975 Phosphate coat per U.S. Army Spec. 57-0-2C, Type II, Class C. Finish with one coat Barrylac traffic marking yellow.

976 Phosphate dip, and one full wet coat of David E. Long Corp., #A-149, yellow paint.

977 Spray with Voplex Corp. polyester resin #331.1352300, yellow paint, and #600.102000 thinner (1 to 1 mix).

978 One coat zinc chromate primer per MIL-P-6889, 2 coats light gray baking enamel per MIL-E-15090, Class 2, Type III.

979 Caustic etch surfaces prior to specified painting operation. One coat zinc chromate primer, and two coats blue semi-gloss baking enamel per Consolidated Eng. Corp., Spec. 24829-941. (May be purchased from Bradley Paint Co., Los Angeles, California).

980 Olive drab endurion and wax.

981 Ebonol "S" (black finish for steel; with lacquer).

982 Medium red baking enamel equivalent of Chem-Lac, Prod. No. 6009.
Two coats zinc chromate primer, per JAN-P-735. One coat Marine Corp. green enamel, per Fed. Spec. TT-E-485B.

Synthetic gray enamel, Industries Sales Corp., type Seal D "202".

Anodize (#600 American Chemical Paint Co.); one coat dull black air-drying enamel.

Ferrous chromate.

Identical to 974.

Lusterless green (olive drab) in accordance with TT-C-595, Color No. 3412. Surface to be bonderized or primed with zinc chromate primer before application of finish coats.

Phosphate dip and two coats zinc chromate primer.

REVA Chemical film per MIL-DTL-5541, Class 1A. One coat of zinc chromate primer, 0.4 to 0.6 mil (dry film) thick per MIL-P-6889; one coat semi-gloss enamel (Green No. 2430), per TT-C-595 and TT-E-529.


Similar to 953, except masking as per drawing.

Alodine 100, per Bendix Spec. BM843A.

Yellow machine enamel.

Red machine enamel.

Green machine enamel.

Electrolize, .0001 to .0002 thick.

One coat zinc chromate primer per MIL-P-6889, Type I. Two coats dull black enamel per MIL-E-11237. Masking required as per drawing.

Zinc chromate primer per MIL-P-6889, Type II. Lusterless enamel (baked or air dried) per TT-E-527, Color 3725 (black) per TT-C-595.

ANODIZE WITH FINISH VARIATIONS
Effectivity Date: 6/10/2016

6001 Identical to Finish #602, except color to be matched with color chip marked "20593".

6002 Bright black anodize: Alcoa #R5 chemical brightener and chromic acid process, per Spec. MIL-A-8625, Type I, less dichromate seal/zinc chromate primer, per MIL-P-6889. Paint two coats, dull black lacquer; Color Chip #37038 (10° max. gloss). Mask and paint, as required per drawing.

6004 Bright black anodize: Alcoa #R5 chemical brightener and chromic acid process per MIL-A-8625, Type I, less dichromate seal.

6005 Black anodize: chromic acid process per MIL-A-8625, Type I.

6006 Hard anodize per MIL-A-8625, Type III, .003 -.004 thick.

6007 Anodize per Finish 7.1.1 of MIL-STD-171. Apply 1 coat zinc chromate primer, Spec. MIL-P-8585 per MIL-P-6808, and 2 coats (.0007 to .0012 each) enamel, Class 2, per MIL-E-15090.

6008 One coat of zinc chromate primer, 0.4 to 0.6 mil (dry film) thick per MIL-P-8585; one coat lusterless green enamel (Color No. 3412) per TT-C-595 and TT-E-527.

6009 Bright black anodize: Alcoa #R5 chemical brightener and chromic acid process per MIL-A-8625, Type I, less dichromate seal followed by zinc chromate primer per MIL-P-8585. Paint 2 coats dull black enamel per TT-E-527. Color No. 37038 per FED-STD-595. Masking required as specified on applicable drawing.

6010 Bright black anodize: Alcoa #R5 chemical brightener, and sulphuric acid anodize per Spec. MIL-A-8625, Type II*, (not to be used on assembled parts) *less dichromate seal. Followed by zinc chromate primer per MIL-P-8585. Paint 2 coats dull black enamel per TT-E-527, Color No. 37038, per FED. Std. 595. Masking required as specified on applicable drawing.

6011 Black anodize per MIL-A-8625. Type II, Class 2.

6012 Black anodize per MIL-A-8625, Type II, Class 2. Prime with zinc chromate primer per MIL-P-8585. Paint 2 coats dull black enamel per TT-E-527, Color No. 37038, FED-STD-595, masking required as specified on drawing.

6013 Black anodize per MIL-A-8625, Type I or II, Class 2.
6014  Blue anodize per MIL-A-8625, Type II, Class 2.

6015  Anodize and gray die per MIL-A-8625, Type I, Class 2. Color to approximate MIL-E-15090, gray enamel.

6016  Anodize per MIL-A-8625, Type I, Class 1, and paint with darkened green zinc chromate primer, AN Color No. 611; primer to conform with TT-P-1757. Masking required as specified on drawing.

6017  Anodize per MIL-A-8625, Type I. One coat epoxy primer per MIL-P-23377.

6018  Sulphuric acid anodize, and dye gray per MIL-A-8625, Type II, Class 2. Color of dye to match engine gray of FED-STD-595, Color No. 16081.

6019  Apply aluminum conversion coat per MIL-DTL-5541, Class 3. Mask areas indicated by drawing. Anodize per MIL-A-8625, Type I, Class 1.

6020  Anodize per MIL-A-8625, Type III, .002 thk. Mask per drawing.

6021  Anodic coating to MIL-A-8625, Type III, Class 2, Color: olive drab (approximating FED-STD-595, Color Number 34102).

6022  a) Black hardcoat anodize .0015-.0025 thk. per MIL-A-8625, Type III, Class 1, with teflon dispersion coat by the Sanford process.

Approved source of supply:

Duralectra Corporation
Natick, MA 01760

b) Prior to anodizing mask indicated areas as shown on drawing, masked area to be chemical film per MIL-DTL-5541, Class 1A.

6023  Anodize per MIL-A-8625, Type III, Class 1.

6024  Anodize per MIL-A-8625, Type III, Class 1, .002 to .003 thick.
CADMIUM PLATE WITH FINISH VARIATIONS

7002  Cad plate per QQ-P-416, Class 1, Type II, primicoat of wash pre-treatment per MIL-P-15328, applied as a continuous film .0002 to .0005 in. thick. Paint 2 coats light gray enamel, Formula III, per MIL-E-15090, Type II, Class 2.

7003  Cad plate per QQ-P-416, Class 3, Type III, phosphate dip and prime with zinc chromate per MIL-P-6889, and finish with gray enamel (lusterless) per MIL-E-15090, Class 2. Color #36231 per FED-STD-595. Threads must be free of paint.

7004  Cad plate per QQ-P-416, Class 3, Type II, 1 coat zinc chromate primer. Paint lusterless black, Color No. 37038, per FED-STD-595. Masking required as per drawing.

7005  "Finish per MIL-F-14072 - P373E: Cadmium plate .0005 thick per QQ-P-416, Type II, Class 1, prime with one coat 0.2 to 0.3 MIL (dry film) thick per MIL-C-15328. Paint one coat light gray semi-gloss enamel, 1.0 MIL thick per MIL-E-15090".

7006  Cad plate per QQ-P-416, Class 1, Type II. Paint per MIL-F-14072 - P371, semi-gloss light gray enamel per MIL-E-15090, Type II, Class 3.

7007  "Cad plate .0005 min., and yellow dichromate per QQ-P-416, Class 1, Type II, in such a manner as to provide for maximum paint adhesion (when followed by zinc chromate, wash primer and baked enamel). No wetting agent of any kind may be used in rinses at any time in the processing. Finished parts must NEVER be delivered to us less than 24 hours after dichromating".

7008  REVA  Cad plate per QQ-P-416, Class 1, Type II, one (1) coat zinc chromate primer per MIL-P-6889, and two (2) coats semi-gloss light gray baking enamel per MIL-E-15090, Type III, Class 2.

7009  Same as 7008, except masking required as per drawing.

7010  Cad plate .0005 thick, and golden dichromate dip per QQ-P-416, Class 1, Type II, and paint one coat of black lacquer.

7011  REVB  Cadmium plate per QQ-P-416, Type II, Class 1; primer per TT-P-666, Class A or B; paint per Color 24084 (olive drab) per FED-STD-595 (2 coats).
7012 Cadmium plate .0003 to .0005 thick, and chromate per QQ-P-416, Class 2, Type II. Chromate treatment shall be of short duration (approx. 5 sec.), such that a bright silvery cadmium surface is produced with no visible iridescent yellow coloration.

7013 Cadmium plate .0003 thick minimum, and Iridite #8 per QQ-P-416, Type II, Class 2. Prime one coat, 0.75 to 1.25 MIL. Dry film thickness of Phenolic primer coating per MIL-P-12742. Apply 1.50 to 2.50 MIL dry film thickness of Phenolic enamel in accordance with TT-E-522, modified to match Marine Corps. Green #23, gloss infrared reflectance optional.

7014 Cadmium plate and chromate per QQ-P-416, Class 3, Type II. Chromate treatment shall be of short duration (approximately 5 seconds) such that a bright silvery cadmium surface is produced with no visible iridescent yellow coloration.

7015 Identical to 768, except masking required as specified on drawing.

7016 Cadmium plate per QQ-P-416, Type II or III, Class 1, one coat of zinc chromate primer 0.4 to 0.6 mil (dry film) thick per MIL-P-8585, or one coat of synthetic paint primer 0.8 mil minimum (dry film) thick per TT-P-636, or TT-P-664. Paint with (1) coat lusterless olive drab enamel, 1.0 to 1.5 mil (dry film) thick per TT-E-527, Color No. 34087 per FED-STD-595. (Finish M224 & P371A per MIL-F-14072).

7017 Identical to 7016, except masking required as specified on drawing.

7018 Cadmium plate per QQ-P-416, Type II, Class 1. Apply 2 coats of paint, enamel, alkyd, lusterless, Comp. G, Color #36236 (gray) per TT-E-527. Do not paint threads.

7019 Cadmium plate .0005 minimum thickness per QQ-P-416, Class 1, Type III. Epoxy paint per MIL-P-23236, Class 2 (color, black), Type I. Paint the steel surfaces with coating system as required to obtain the number of coats, and a dry minimum total thickness as specified by each manufacturer listed in the qualified products list, QPL 23236.
7020 Cadmium plate and olive drab iridite per QQ-P-416, Type II, Class 1 (Barry 718). Then prime with pre-treatment coating, 0.2 to 0.3 mil (dry film) thick per MIL-P-15328, followed by either 1 coat of zinc chromate primer, 0.3 to 0.6 mil (dry film) thick per MIL-P-8585, or one coat of synthetic paint primer, 0.8 mil minimum (dry film) thick per TT-P-636. Paint with 1 coat lusterless olive drab enamel, 1.0 to 1.5 MIL (dry film) thick per TT-E-527, Color No. 34087 per FED-STD-595. Priming and painting to be applied to only those surfaces specified on the applicable drawing.

7021 Cancelled.

7022 REVA Zinc plate, Type II, FE/ZN8, in accordance with ASTM B633. Wash primer per MIL-P-15328, applied as a continuous film, .0002 to .0005 thick followed by one (1) coat of zinc chromate primer per MIL-P-8585 applied as a continuous film .0005 to .0010 thick. Apply two (2) coats of gray enamel per MIL-E-15090, FE/ZN8, applied as continuous films approximately .001 thick.

7023 Same as 7022, except masking required as per drawing before priming and painting.

7024 Cadmium plate, per QQ-P-416, Class 2, Type II. Hydrogen embrittlement relief, 3 hrs. minimum at 375° ± 25° F, within 1 hr. after plating.

7025 Cadmium plate per QQ-P-416, Class 2, Type II. Omit plating in area specified on drawing.

7026 .0002" min., bright cadmium plate with luster-on (trademark of the Chemical Corp.).

7027 Grit blast, then cadmium plate per QQ-P-416, Type II, Class 2.

7028 (For parts previously finished per 7027). Apply 1 coat zinc chromate primer per TT-P-1757, Color Y, and 2 coats of light gray enamel per MIL-E-15090, Type II, Class 2. Mask as required per drawing.

7029 Cadmium plate per QQ-P-416, Type II, Class 2. Apply 1 coat of zinc chromate primer per TT-P-1757, Color Y, and 2 coats of light gray enamel per MIL-E-15090, Type II, Class 2.
7030 Cadmium plate per QQ-P-416, Type II, Class 1 (Barry 708). Prime with pretreatment coating, 0.2 to 0.3 mil (dry film) thick per MIL-P-15328, either one coat zinc chromate primer, 0.3 to 0.6 mil (dry film) per MIL-P-8585, or 1 coat of synthetic paint primer, 0.8 mil min. (dry film) thick per TT-P-636, 1 coat semi-gloss gray enamel per TT-E-529, FED-STD-595, Color #26152 (Finish M224 and P371F of MIL-F-14072).

7031 Cadmium plate per QQ-P-416, Type II, Class1. Pretreatment coating per MIL-C-8514. Zinc chromate per TT-P-1757. Paint per MIL-F-14072, lusterless forest green per MIL-E-52835.

7032 Identical to 7031, except masking required as specified on drawing.

7033 (Applies to parts which have been previously plated per Barry 712). Mask as required. Apply 1 coat of zinc chromate primer per TT-P-1757, Color Y, and 2 coats of light gray enamel per MIL-E-15090, Type II, Class 2.

7034 REVA Cadmium plate per QQ-P-416, Class 1, Type I.

7035 REVA Cadmium plate per QQ-P-416, Class 1, Type III. Prime with zinc chromate primer per TT-P-1757, Color Y. Paint with light gray enamel per MIL-E-15090, Type III, Class 2. Mask as specified on drawing.

7036 Cadmium plate per QQ-P-416, Type II, Class 1 (Barry 708). Pretreatment coating per MIL-P-53288. One coat primer per TT-P-1757, lusterless forest green enamel (0.381-0.0508 mm thick) per MIL-E-52798. (Finish M224 & P371.1 V per MIL-F-14072).

7037 Identical to 7036, except masking required as specified on drawing.

7038 Cadmium plate per QQ-P-416, Class 2, Type II, except bake at 275° F ± 25° for 6 to 8 hours within 4 hours after plating. Certificate of Conformance required.

7039 Cadmium plate per QQ-P-416, Type II, Class 1 (Barry 708). Phosphate treat per TT-C-490, Type I. Prime with zinc chromate primer per TT-P-1757, Color Y, and finish with 2 coats of light gray enamel per MIL-E-15090, Type II, Class 2, Color #26307 per FED-STD-595 (Barry 9336).

7040 Cadmium plate with gold dichromate dip per QQ-P-416, Class 1, Type II, except thickness to be .001 minimum.
7041 Cadmium plate in accordance with QQ-P-416, Type II, Class 2, over copper plate in accordance with MIL-C-14550, Class 4. Bake for Hydrogen embrittlement relief.

ZINC PLATE WITH FINISH VARIATIONS

8001 REV B Zinc plate per ASTM B633, Class FE/ZN 12, Type IV. 1 coat synthetic primer per TT-P-636. Two coats semi-gloss, olive drab enamel per TT-E-529, Color No. 24084 per FED-STD-595.

8002 REV B Zinc plate .0002 to .0003 thick per ASTM B633, Class FE/ZN 5, Type IV. One coat of zinc chromate primer per MIL-P-8585. Paint two coats semi-gloss, olive drab enamel, Color No. 24084 per FED-STD-595.

8003 Identical to 819, except masking required as per drawing.

8004 REV B Zinc plate .0002 to .0003 thick per ASTM B633, Class FE/ZN5 Type I, phosphate Grade I per TT-C-490, one coat zinc chromate primer per MIL-P-8585. Paint per Fin. No. 21.3 of MIL-STD-171B, Color No. 24201, FED-STD-595.

8005 Do not use.

8006 Primer: one coat of wash pretreatment in accordance with MIL-P-15328, applied as a continuous film 0.0002 to 0.0005 inch thick, or hot dip-tank phosphate treatment per TT-C-490, Type I, followed by one coat of primer per TT-P-664, or MIL-P-8585 applied as a continuous film 0.0002 to 0.001 inch thick. Finish: two coats of formula III, gray semi-gloss enamel according to MIL-E-15090, Type III (baking), Class 2 (semi-gloss).

8007 REV A Zinc plate and golden dichromate dip per ASTM B633, Class FE/ZN 12, Type II, in such a manner as to provide for max. paint adhesion. (No wetting agent of any kind is to be used in rinses). Follow, NEVER less than 24 hours after dichromating, with one coat of primer per Spec. TT-P-664, or MIL-P-8585, applied as a continuous film, .0002 to .001 inch thick, and two coats of light gray enamel per MIL-E-15090, Type III, Class 2 (baked as continuous films approximately .001 inch thick).

8008 REV A Zinc plate and golden dichromate in such a manner, as to provide for max. paint adhesion and dip per ASTM B633, Class FE/ZN 12, Type II. Masking per drawing, if required, (when followed by zinc chromate wash primer baked enamel). No wetting agent of any kind may be used in rinses at any time in the processing. Finished parts must never be delivered to us less than 24 hours after dichromating.
8009 Zinc plate per ASTM B633, Class FE/ZN 8, Type II, or Type III.

8010 **REVA** Zinc plate per ASTM B633, Class FE/ZN 12, Type II, or Type III. Prime by applying pretreated coating, 0.2 to 0.3 MIL. (Dry film) thick per MIL-C-15328, followed by either one coat of synthetic paint primer, 0.8 MIL minimum (dry film) thick, per TT-P-636, or one coat of zinc chromate primer 0.4 to 0.6 MIL, (dry film) thick per MIL-P-6889. Paint with one coat semi-gloss enamel per TT-E-529, Color X24-087 per MIL-STD-795, 1.0 MIL thick.

8011 Identical to 8010, except masking per drawing.

8012 Zinc plate per ASTM B633, Class FE/ZN 25, Type I.

8013 1. Zinc plate per ASTM B633, Class FE/ZN 25, Type II or Type III.
2. Paint in accordance with Barry Data Sheet 954.

8014 Identical to 8013, except masking or other qualifications as per drawing.

8015 1. Zinc plate per ASTM B633, Class FE/ZN 25, Type II or Type III.

8016 Zinc plate .00015 thick.

8017 Zinc plate .0002 to .0003 thick, and black supplemental dip per ASTM B633, Class FE/ZN 5, Type II.

8018 **REVA** Zinc plate per ASTM B633, Class FE/ZN 12, Type II or Type III. Mask areas as per drawing; hot dip-tank phosphate treatment per TT-C-490, Type I; one coat of primer per TT-P-644 or TT-P-1757 applied as a continuous film .0002 to .001 thick; paint per MIL-E-15090, Type III, Class 2; two coats of light gray enamel (baked) as continuous films, each (approx.) .001 thick, Color No. 26307 per FED-STD-595.

8019 Zinc plate per ASTM B633, Class FE/ZN 5, Type IV. Apply one coat of primer 0.0005 to 0.002 inch film thickness per TT-P-664. Apply two coats of gray enamel (Formula No. 111) per MIL-E-15090, Type III, Class 2 as continuous film, each approximately 0.001 inch thick.

8020 Phosphate treat per TT-C-490, Type I, or grit blast. Prime with zinc chromate primer per TT-P-1757, Color Y. Masking required as per drawing before priming.
8021 (For parts previously finished per Suffix 8020). Mask as per drawing, and apply 2 coats of light gray enamel per MIL-E-15090, Class 2.

8022 **REVA** Zinc plate with supplemental olive-drab chromate dip per ASTM B633, Class FE/ZN 12, Type II.

8023 1. Zinc plate per ASTM B633, Class FE/ZN 25, Type II or Type III.
2. Paint in accordance with Barry Data Sheet 1095.
3. Mask as specified on drawing.

8024 **REVA** A. Zinc plate per ASTM B633, Class FE/ZN 12, Type II or Type III.
B. Prime, wash, pretreatment blue (Formula No. 117-B, for metals) per MIL-P-15328.
C. One coat primer 0.8 MILS min. thick (dry film) per TT-P-636.
D. One coat green paint per TT-E-529, Color No. 24533 per FED-STD-595, 0.0254-0.381 MM (0.001-0.0015 mils) thick dry film.
E. Masking required as specified on drawing.

8025 **REVA** Zinc plate per ASTM B633, Class FE/ZN 12, Type II (Barry 808). Pretreat per MIL-P-15328; one coat primer per TT-P-1757; paint with black lusterless enamel, ALKYD (.0254-.0381 MM thick) per TT-E-527, Color No. 37038 per FED-STD-595. Masking or other specifications per drawing.

8026 **REVA** Zinc plate, per ASTM B633, Class FE/ZN12, Type II.

8027 **REVA** Bright zinc plate per ASTM B633, Class FE/ZN 12, Type I. One coat primer per MIL-P-23377, Type II. Masking required when specified on drawing.

8028 Paint procedures per MIL-STD-193, prime per TT-P-1757. Paint with forest green enamel per MIL-E-52798, or MIL-E-52835.

8029 Zinc plate per ASTM B633, Class FE/ZN 8, Type II.

8030 **REVA** Identical to 804.

8031 Zinc plate per ASTM B633, Class FE/ZN 8, Type IV.

8032 **REVA** Identical to 805.

8034 Zinc plate per ASTM B633, Class FE/ZN 25, Type II.

8035 Zinc plate per ASTM B633, Class FE/ZN 25, Type III.

8036 **REVA** Electroless nickel plate per MIL-C-26074 or AMS2404, .0001 thick followed by zinc plate per ASTM B633, Class FE/ZN 5, Type III.
8037 REVA  Zinc plate per MIL-F-14072, Finish Number M226, per ASTM B633, Type II, Class FE/ZN 12.

8038  Finish 1.9.2.3 of MIL-STD-171, except .0003 thick.

8039 REVA  Zinc plate per ASTM B633, Class FE/ZN 12, Type II. Bake at 375°F min. for 3 hours within 4 hours of electroplating. Baking operation shall be performed after plating and before dichromate treatment.

8040  CARC painted in accordance with MIS-20007, Type I, Condition B, Grade 1 over zinc plating with chromate conversion coating in accordance with ASTM B633, Type II, SC3 or SC4.

Zinc plating and chromate conversion coating must be performed by a Raytheon approved processor listed in Raytheon document QN 050. The processor must provide a certificate of analysis with each lot with the following information:

- Processor’s Name and Address
- Purchase Order Number
- Part Number, Revision and Lot Quantity
- Each process applied to the item(s) covered in the purchase order.
- Actual test results (composition, thickness, adhesion, etc…)

Facility performing the painting must be a Raytheon approved facility listed in Raytheon document QN 090. Per paragraph 1.3 of Raytheon document QN 090, the facility performing the painting must supply a Certificate of Conformance with the parts that lists the following:

- Supplier’s Name
- MIS-20007
- Part Number
- Thickness and dry tape tests were performed and meets the requirements of MIS-20007.
- Weekly wet tape tests were performed on the parts while CARC painting the parts per MIS-20007.
- Raytheon Approval Form per paragraph 2.1 of Raytheon document QN 090.

All drawing dimensions apply before painting. Paint shall not be applied to threaded holes. Unless otherwise specified on the drawing, paint shall be applied to all non-threaded holes.


8042  Finish per Army TACOM drawing 12469117 (Cage Code 19207). This finish is known within AM General as the “Dorrltech type finish” or as Magni 560 or Magni 565.

8043  Zinc Nickel Alloy Plate Per AMS 2417, Type 2.

8044 REVA  Zinc plate per ASTM B633, Type II, Fe/Zn 12 (SC3) or FE/Zn 25 (SC4)
MISCELLANEOUS

9001 Nickel plate per ECI Spec. #49-00038-039.

9002 Prime one coat of wash pretreatment per MIL-P-15328, applied as a continuous film .0002 inches thick. Paint two (2) coats light gray enamel Formula III per MIL-E-15090, Type II, Class 2.

9003 Passivate (treatment of stainless steel 416, 17-4 PH and 17-7 PH only) after heat treat using Virgo Descale (Wheeler Chemical Company) or equal.

9004 REVA Chromate conversion coat per MIL-DTL-5541, Class 1A. Prime with zinc chromate primer per MIL-P-8585. Finish with light gray enamel per MIL-E-15090, Class 2.

9005 Iridite 14-4, and light gray enamel per MIL-P-15090, Type II, Class 2, color per FED-STD-595 No. 26307 (paint supplied by ARMA Corp.).

9006 One coat pretreatment primer per MIL-P-15328; one coat primer per MIL-P-8585, Color Y; two (2) coats gray enamel per MIL-E-15090, Type III, Class 2.

9007 Identical to 9005, except masking required as per drawing.

9008 REVA Alum. conversion coat per MIL-DTL-5541, Class 1A. Paint one (1) coat zinc chromate primer per MIL-P-8585, and two (2) coats enamel per TT-E-527, baked, Color No. 37038 per FED-STD-595. Masking required as per drawing.

9009 Nickel plate per QQ-N-290, Class 2, over cadmium plate per QQ-P-416, Class 2, Type I.

9010 Do not use.
9011 Caustic etch zinc chromate primer per MIL-P-6889, Type I. Finish with black wrinkle enamel per MIL-E-5558. Masking per drawing.

9012 Caustic etch zinc chromate primer per MIL-P-6889, Type I. Finish with black lusterless synthetic enamel, Grade I, per Spec. AN-E-13. Masking per drawing.

9013 Black endurion and profilm #1001 coating per MIL-P-16232, Class 4E.

9014 Silver plate .0005 thick per Spec. QQ-S-365, Type II.

9015 Non-etchant alkaline solution, and Iridite #14-9, clear and colorless per MIL-DTL-5541.

9016 Zinc chromate primer per MIL-P-8585 and gray enamel per TT-E-529, Class B, Collins Color Number 225.

9017 REVA Nickel plated, Class 1, Grade C, (DS) (.002 thick copper plus nickel). Matte finish per Spec. QQ-N-290.

9018 Silver lacquer.

9019 Brass plate .00015 to .00020 thick, and water dip lacquer.

9020 REVA Nickel plated per QQ-N-290, Class 2, .0005 thick.

9021 Pretreatment coating 0.0002 to 0.0003 thick per MIL-C-15328, followed by one coat of zinc chromate primer, 0.0004 to 0.0006 thick per MIL-P-8585. Finish, paint one coat of semi-gloss baking enamel per TT-E-529, Color No. 26231 of FED-STD-595, thickness 0.001, bake per MIL-F-14072.

9022 Black semi-gloss lacquer.

9023 Zinc chromate primer in accordance with MIL-P-8585, Type II.

9024 Commercial brass plate.

9025 Zinc chromate primer per MIL-P-8585; one coat of semi-gloss black enamel per TT-E-529, Color No. 27038 of FED-STD-595. Finish to be in accordance with Bendix Corporation Finish No. 1854025. Masking required as per drawing.

9026 One coat of zinc chromate primer per MIL-P-8585, Color Y, and finished with 2 coats of gray enamel per MIL-E-15090, Class 2, Type III.

9027 Identical to 9026, except masking required as per drawing
Pretreat surface in accordance with MIL-DTL-5541, Class 1A. Apply one coat zinc chromate primer per MIL-P-8858 (AER) in accordance with MIL-P-6808 (ASG), apply two (2) coats ANA604 camouflage black enamel per MIL-E-5556. All finishes shall be applied in strict accordance with MIL-F-7179 and MIL-F-18264.

P513 per Spec. MIL-F-14072, (chemical film to be yellow iridescent color). Paint final film with one (1) coat of lusterless enamel, .001 min. thick per TT-E-527, Color No. 36231, dark gull gray per FED-STD-595. Primer and paint all edges and surfaces indicated ONLY. Bake at 225°F max.

Cad plate per M252 of MIL-F-14072, followed by pretreatment coating 0.2 to 0.3 mil (dry film) thick per MIL-C-15328; followed by one (1) coat of rust inhibiting primer 0.6 mil minimum (dry film) thick per MIL-P-11414; followed by two (2) coats 0.001 thick, each of light gray semi-gloss enamel (Formula 111) per MIL-E-15090.

See Data Sheet 889.

Passivate per QQ-P-35. Prime with zinc chromate primer per TT-P-1757, Color Y, and finish with light gray enamel per MIL-E-15090, Class 2.

Passivate per QQ-P-35. Prime with one (1) coat (.0005 to .001 thick) of zinc chromate primer per TT-P-1757, Color Y, and finish with two (2) coats (approx. .001 thick each coat) of light gray enamel per MIL-E-15090, Class 2. Mask where required.

Identical to 608, except masking required as per drawing.

Houghto-black 15, (E.F. Houghton & Co.) per MIL-C-13924, Class 1, Grade A, B, & C.

Black Epoxy paint per MIL-PRF-23236, Types V, VI or VII, any Class except 15, Grades A, B or C, but Grade C is preferred. Please note that MIL-PRF-23236 has made Type I and Classes 1 and 2 obsolete.

A. Wipe steel surfaces clean of grease, and oil with a clean rag; wet with solvent.
B. Sandblast steel surfaces.
C. Paint the steel surfaces with coating system as required to obtain the number of coats, and a dry minimum total thickness as specified by each manufacturer listed in the Qualified Products List (QPL 23236).

CAUTION REQUIRED WHEN MIXING OR APPLYING PER DATA SHEET 1155.

Nickel plate, Class 1, Grade C per QQ-N-290.
Cadmium plate per QQ-P-416, Type II or III, Class 1. Prime by applying pretreatment coating, 0.2 to 0.3 mil (dry film) thick per MIL-C-15328, followed by either one coat of synthetic paint primer, 0.8 mil minimum (dry film) thick, per TT-P-636, or one coat of zinc chromate primer, 0.4 to 0.6 mil (dry film) thick, per MIL-P-6889. Paint with one coat semi-gloss enamel per TT-E-529, Color X24-087 per MIL-STD-795, 1.0 mil thick.

Prime by applying pretreatment coating, 0.2 to 0.3 mil (dry film) thick per MIL-C-15328, followed by either one coat of synthetic paint primer, 0.8 mil minimum (dry film) thick, per TT-P-636, or one coat of zinc chromate primer, 0.4 to 0.6 mil (dry film) thick, per MIL-P-6889. Paint with one coat semi-gloss enamel per TT-E-529, X24-087 per MIL-STD-795, 1.0 mil thick. Mask per drawing.

Apply one coat of rust inhibiting zinc chromate primer (dip or spray). Apply two coats of semi-gloss gray enamel, Color 26373, in accordance with FED-STD-595, "Colors". Each finish coat (Type II or III) shall be free from checking, dulling, wrinkling, and other imperfections.

Prime one (1) coat per MIL-D-8585, .0005 to .001 thick. Paint two (2) coats of gray enamel per MIL-E-15090, Class 2 (approx. .001 thick each coat). Mask where required.

Silver plate .0002/.0004 thick, Type II, Grade B per QQ-S-365.

Cadmium plate per QQ-P-416, Type II, Class 1. One coat zinc chromate primer per MIL-P-8585, 2 coats of green enamel paint per TT-E-489, Color Number X14050.

Primer with zinc chromate primer per MIL-P-6889. Paint two coats dull black lacquer. Color Chip #37038 (10° max. gloss). Masking required as per drawing.

Identical to 648, except masking required as per drawing.

Passivate per QQ-P-35.

Phosphate coat type "M", Class 2 per MIL-P-16232.

Aluminum conversion coat, Turco #4178-6 per MIL-DTL-5541. Prime with zinc chromate primer per MIL-P-6889. Paint one (1) coat dull black lacquer, Color Chip #37038 (10° max. gloss) per FED-STD-595.

Cad plate .0002 to .0003 thick and chromate dip, per QQ-P-416, Class 3, Type II. Mask per drawing. One coat zinc chromate primer per MIL-P-6889. Paint olive drab, 24084, per FED-STD-595.
9050  REVA  Iridite, clear, per MIL-DTL-5541, Class 1A.

9052  Identical to 9051, except masking required per drawing before priming and painting.

9053  REVA  Aluminum conversion coat per MIL-DTL-5541, Class 3. Color to be yellow unless otherwise specified.

9054  Prime with 2 coats zinc chromate primer per MIL-P-8585. Paint 2 coats FED-STD-595, Chip #36231, color gray per TT-E-527.

9055  REVA  Mask as required per drawing before priming and epoxy coating. Apply one coat of pretreatment wash primer per DOD-P-15328 and one coat epoxy primer per MIL-P-23377. Apply one coat of epoxy top coat in accordance with MIL-C-22750 and conforming to color chip #36231 of FED-STD-595.

9056  One coat wash primer per MIL-C-8514 to a dry film thickness of 0.0002 to 0.0003 inches. Prime per MIL-P-7962, 0.0003 to 0.0004 inches thick. 2 coats of Color No. 26307 (FED-STD-595) per MIL-L-19538.

9057  Wipe metal clean with lacquer thinner, and apply one coat of light gray air dry lacquer per Colonial Lacquer and Chemical Co. L1S-16. Color to be in accordance with color chip in possession of inspection department.

9058  Tousey 2-1449, beige primer, Tousey 2-1448, beige enamel, FED-STD-595, Chip #23690 per HP Spec. #187-D-130 (Allis-Chalmers).

9059  REVA  Chemical film per MIL-DTL-5541, Class 1A. Apply 2 coats of primer (0.001 to 0.002 dry film thickness) per MIL-P-8585. Apply 2 coats gray baking enamel per Type III, Class 2, of MIL-E-15090 to be applied as continuous films approx. .001 thick. Mask as specified on drawing.

9060  REVA  Aluminum conversion coat (Torco 4178-6) per MIL-DTL-5541, Class 1A, zinc chromate primer per MIL-P-8585, blue baked enamel (Wright Line #001655).

9061  Identical to 9060, except mask per drawing.

9062  Obsolete Zinc chromate primer per MIL-P-8585, blue baked enamel (Wright Line #001655).

9063  Identical to 9062, except mask per drawing.
9064 REVA  Aluminum conversion coat (Torco 4178-6) per MIL-DTL-5541, Class 1A. Zinc chromate primer per MIL-P-8585, black semi-gloss baked enamel.

9065  Identical to 9064, except mask per drawing.

9066  Zinc chromate primer per MIL-P-8585, black semi-gloss baked enamel.

9067  Identical to 9066, except mask per drawing.

9068  Dry film lubricant process per MIL-L-8937.

9069  ASA #49 gray paint.

9070  Black enamel (baking) semi-gloss. Consists of 75% gloss, and 25% semi-gloss as purchased from Colonial Lacquer.

9071  White bake enamel--"Waterlac" #2013.

9072  2 coats of lacquer sealer and 1 coat semi-gloss white lacquer.

9073  Selac vinyl baking enamel, green Coritex 63P-L11494.

9074 REVA  Chromate conversion coat per MIL-DTL-5541, Class 1A. Zinc chromate primer per MIL-P-6889. 2 coats light gray semi-gloss baking enamel per MIL-E-15090, Class 2, Type III, Color No. 26307 per FED-STD-595. Masking required as per drawing.

9075  Tin plate .0003 to .0004 thick per MIL-T-10727, Type I.

9076 REVA  Chemical film treatment per MIL-DTL-5541, Type II, Class 2, color iridescent yellow (Turco Accelagold).

9077  Vinyl zinc chromate primer, Navy STD Formula 120 per MIL-P-15930 (one coat), and Navy STD Formula 122-46 gray per MIL-P-16502 (2 coats).

9078 REVA  Nickel plate per QQ-N-290, Class 1, Grade C.

9079  Chemical conversion coat in accordance with Bendix Manufacturing Specification BM-843-2, or equivalent.

9080  Phosphate dip, 1 coat zinc chromate primer, paint dull black enamel, Color No. 37038, FED-STD-595.
9081 Phosphate coat, primer coat per BUWEPS 2801482-02, or 2801482-03. Paint one coat semi-gloss vinyl per BUWEPS 2801429-29, light gray color to match BUSHIPS Color Card Formula No. 111, Class 2, per MIL-E-15090 with application per BUWEPS 2801100.

9082 Same as 9081, except masking required as specified on applicable drawing.


9084 Sand blast outside surfaces only, and black oxide per MIL-C-13924, Class 2.

9085 Commercial brass plate.

9086 Passivate per QQ-P-35. 1 coat Devran 201 green, 1 coat Devran 201 buff, and 1 coat Devran 209 black. Celanese Coatings Co., Devoe Marine Division, Newark, NJ 26225.

9087 Black passivate - no post treatment dip.

9088 Black passivate, dip in oil, wipe to remove excess.

9089 Insignia red air dry enamel.

9090 Phosphate treat per TT-C-490, Grade I (bonderite or equiv.), after which surfaces shall be primed with zinc chromate primer, Type I, in accordance with MIL-P-6889, and finish with blue enamel, Color No. 25189 of FED-STD-595.

9091 REVB Mask as required per drawing before priming and epoxy coating. Chromate conversion coat per MIL-DTL-5541, Class 3. Apply one coat of pretreatment wash primer per DOD-P-15328 and one coat epoxy primer per MIL-P-23377. Apply one coat of epoxy top coat in accordance with MIL-C-22750 and conforming to color chip #36231 of FED-STD-595.

9092 Vibrate tumble approximately 30 minutes using aluminum oxide, Grade "C" media in a solution of 1-1 1/2% ESBEC #1205 and water.

9093 Identical to 9090, except masking required as per drawing.

9094 Finish per Data Sheet 885.

9095 Finish per Data Sheet 919.

9096 REVA Chromate conversion coat per MIL-DTL-5541, Class 1A. Prime with one coat of zinc chromate primer per MIL-P-8585. Two coats of ename per MIL-E-7729 or MIL-E-5556, Color 27038 per FED-STD-595, bake 3 hours at 225° F (semi-gloss black).
9097 Identical to 9096, except mask per drawing.

9098 Prime with black paladin primer #12412. Paint with black semi-gloss enamel, Type ROXYN EK-4542-1, and bake at 250° C for one hour.

9099 Identical to 9098, except mask per drawing.

9100 Apply coating per Data Sheet 885. Paint surfaces specified on drawing with one coat of orange-yellow lacquer No. 614, complying with MIL-L-19538 (AER).

9101 Textured sepia (24091) vinyl organsol (M & T Chemicals).

9102 Clean and degrease thoroughly. Phosphate dip per TT-C-490, Type I, or grit blast all over. Paint with epoxy paint complying with MIL-P-23236, Type I, Class 1 or 2 (color-black). Coating system to be as required to obtain the number of coats, and a dry minimum total thickness as specified by each manufacturer listed in QPL 23236. Masking required as specified on drawing.

9103 Clean, prime and paint per MIL-F-14072, P213Y (forest green). Masking as specified on drawing.

9104 Chromate dip, prime and paint per MIL-F-14072, P513Y (forest green). Masking required as specified on drawing.

9105 REVA Chromate conversion coat per MIL-DTL-5541, Class 1A. One coat zinc chromate primer per MIL-P-8585, two coats black semi-gloss enamel per TT-E-489, Color 27038 per FED-STD-595, and bake 1 hour at 275° F. Mask as required.

9106 Black paladin primer 12412. Paint with black semi-gloss enamel per TT-E-489, Color 27038 per FED-STD-595, and bake 1 hour at 275° F. Mask as required.

9107 Chromate conversion coat per MIL-DTL-5541, Class 1A (iridite 14.2). Mask as required prior to painting. Wash prime per MIL-P-15328, yellow .0002-.0005 thick dry film inside and outside surfaces.

One coat zinc chromate primer per MIL-P-8585. .0005-.0008 thick dry film (color-yellow) inside and outside surfaces.

One coat .004 thick per MIL-W-5044, Type II, dark grey enamel, Color 36231 per FED-STD-595 (outside surfaces only). Air dry for 8 hour (non-slip walkway finish).
9108 Chromate conversion coat per MIL-DTL-5541 Class 1A (Iridite 14.2). Mask as required prior to painting. Wash prime per MIL-P-15328 yellow .0002-.0005 thk. dry film inside and outside surfaces.

One coat zinc chromate primer per MIL-P-8585 .005 - .0008 thk. dry film (color yellow) inside and outside surfaces.

Two coats lusterless enamel per TT-E-527 dark gull grey color 36231 per FED-STD-595, .001-.002 thk. dry film each coat (outside surface only). Air dry for 8 hours.

9109 Acrylic coating per data sheet #924 (Johnson Wax CDX 77-1).

9110 Same as suffix 9109 except masking required as specified on drawing.

9111 Blue-Grey Wrinkle Enamel #7500-161 Cardinal Ind. finishes 1329 Potrero, South El Monte, California.

9112 Brass Plate 70 Cu/30Zn for bonding elastomer (Ref. .00005 Thk).

9113 Phosphate treat per TT-C-490 (Fed), wash primer per MIL-P-15328 & paint 2 coats light gray enamel per MIL-E-15090 Type III CL2 or Type II CL2.

9114 Passivate; Paint one coat brown primer per TT-P-664; paint 2 coats gray enamel per MIL-E-15130.

9115 Identical to 9114 except masking or other qualifications as specified on drawing.

9116 Clear Epoxy paint per MIL-C-22750.

9117 Phosphate Treat Per TT-C-490, Type II. Wash Prime Per MIL-P-15328 Zinc Chromate Prime Per MIL-P-8585, Spray 2 coats baking enamel per TT-E-489, Class B. Color shall be light Admiralty Grey conforming to British Standard 381C, Color No. 697. Final Dry Film Thickness, .001 Minimum.

9118 Identical to 9117 except masking required as specified on drawing.

9119 Chromate Dip Per MIL-DTL-5541 Class 1A (Do not dip in caustic).

9120 Identical to 977 except masking required as specified on drawing.
9121 REVA  Chemical film per MIL-DTL-5541, Class 1A, after which surface shall be primed .0002 to .0010 thick with zinc chromate primer per MIL-P-8585. Then painted per MIL-E-15090, Class 2, Type III, gray, semi-gloss enamel, baked. Masking or other specifications as per drawing.

9122 Cancelled.


9124 Applies to sub-assemblies consisting of components finished prior per 7007. One (1) coat zinc chromate primer per MIL-P-6889, and two (2) coats semi-gloss light gray baking enamel per MIL-E-15090, Type III, Class 2 (masking required per drawing).

9125 Cancelled.

9126 One coat wash primer (pretreatment coating) per MIL-C-8514. One coat zinc chromate primer per MIL-P-8585. Two coats semi-gloss gray enamel (Color No. 26373 of FED-STD-595) applied per MIL-F-18264, mask as per drawing. Enamel to be per TT-E-529, Class B, Comp G.

9127 Paint with light gray semi-gloss air drying paint, Voplex No. 93113657, or Eng. approved equiv. mask as indicated on drawing.

9128 Caustic etch and oven dry per Data Sheet No. 946.


9130 Armorhide textured plastic finish per Data Sheet 950.


9132 (A) Grit blast to white metal.
   (B) Immediately after grit blasting, apply Tarset MCR-43 epoxy primer, and allow to air dry for 18 hours minimum.
   (C) Immediately after primer has dried, apply first finish coat of Tarset black epoxy paint per MIL-P-23236, Type I, Class 1 or Class 2, and allow to air dry for 6 to 8 hours, or until "set to touch".
   (D) Immediately after first finish coat has "set to touch," apply second finish coat and bake at 150° F for 4 to 6 hours minimum.
9133  Same as 9132, except masking required as specified on drawing.

9134  Chromate conversion coat per MIL-DTL-5541, Class 3. Prime per FED Spec. TT-P-1757 (G.E. Specification F31G-WB3) and paint with Color #36231 per FED-STD-595.

9135  One coat of zinc chromate primer per MIL-P-8585, Color Y, and finished with 2 coats of gray enamel per MIL-E-15090, Class 2, Type II.

9136  Alodine 1200, color olive drab to dark straw.

9137  Cadmium plate, Class 1, Type II in accordance with QQ-P-416. Prime with accordance with MIL-P-15328, applied as a continuous film .0002 to .0005 inch thick, or a hot dip tank phosphate treatment conforming to Type I of TT-C-490, followed by one coat of primer in accordance with TT-P-1757 applied as a continuous film .0005 to .001 inch thick shall be applied to the parts. Finally (2) coats of gray enamel, conforming to Class 2 of MIL-E-15090, shall be applied as continuous films approximately .001 inch thick.

9138  Same as 9137, except masking required as specified on drawing.

9139  Prime with zinc chromate primer per TT-P-1757, Color Y. Paint with 2 coats of light gray enamel per MIL-E-15090, Class 2. Mask as required on drawing.

9140  Same as 9080, except masking required as specified on applicable drawing.

9141  Phosphate dip, one coat zinc chromate primer and two coats enamel, lusterless black, Color No. 37038 per FED-STD-595.

9142  Same as 9141, except masking required as specified on applicable drawing.

9143  Chromate conversion coat per MIL-DTL-5541, Class 1A. One coat zinc chromate primer, .0002-.0010 thick per TT-P-1757, Color Y, two coats gray enamel per MIL-E-15090, .001 thick, Class 2, Type III.

9144  Chemical film per MIL-DTL-5541, Class 1A. One coat of wash primer per MIL-C-8507. One coat of zinc chromate primer per TT-P-1757. Two coats of light gray formula III enamel per MIL-E-15090, Type II, Class 2.
9145 Same as 9144, except masking required as specified on applicable drawing.

9146 Phosphate dip, 1 coat zinc chromate primer .0002 to .0010 thick per TT-P-1757. Paint 2 coats gray enamel per MIL-E-15090, Type III, Class 2, .001 min. thick, Color No. 26307 per FED-STD-595.

9147 Same as 9146, except masking as required.

9148 Phosphate dip and acrylic coat per Data Sheet #924 (Johnson Wax CDX 77-1).

9149 REVA Chemical film per MIL-DTL-5541, Class 1A. Prime with one coat of primer per MIL-P-23377. Paint with one coat of light gray semi-gloss epoxy polyamide per MIL-C-22750, Class 2, FED-STD-595, Color No. 26307, 0.0254-0.0381 (mm) thick. Masking as required per drawing.

9150 Applies to sub-assemblies using components previously finished per Suffix 7007 or 920. Apply wash primer per MIL-P-15328 as a continuous film .0002 to .0005 thick followed by one (1) coat of zinc chromate primer per MIL-P-8585 applied as a continuous film .0005 to .0010 thick. Apply two (2) coats of gray enamel per MIL-E-15090, Class 2, applied as continuous films. Approximately .001 thick. Masking required as specified on drawing.

9151 Passivate per MIL-STD-171, Finish #5.4. Apply wash primer per MIL-P-15328 as a continuous film .0002 to .0005 thick followed by one (1) coat of zinc chromate primer per MIL-P-8585 applied as a continuous film .0005 to .0010 thick. Apply two (2) coats of gray enamel per MIL-E-15090, Class 2 applied as continuous films, approximately .001 thick. Masking required as specified on drawing.

9152 Light gray semi-gloss air drying paint, Voplex No. 93113657, or engineering approved equivalent. Masking required, if specified on drawing.

9153 REVA Chromate dip per MIL-DTL-5541, Class 1A. Epoxy primer per MIL-P-23377, thickness .0007 max. Paint with epoxy enamel per MIL-C-22750, Color No. 26555 (beige) per FED-STD-595 thickness .0017 max. Masking required as specified on drawing.

9154 Reserved by RFS 5/28/75, FCR Dwg. 7210018.

9155 Chromate conversion coat per MIL-DTL-5541, Class 1A. One coat zinc chromate primer per TT-P-1757, Color Y. Two coats light gray semi-gloss air drying enamel per MIL-E-15090, Class 2, Type II. Mask as required per drawing.
9156 Black nitrate on stainless steel.

9157 Prepare and coat metal surfaces per Paragraphs I and II of Data Sheet 975.

9158 Phosphate treat per TT-C-490, Type I. Apply wash primer per MIL-P-15328 followed by one (1) coat zinc chromate primer per MIL-P-8585, and two (2) coats gray enamel per MIL-E-15090, Class 2. Masking required as specified on drawing.

9159 Reserved by FCB.

9160 Electropolish per Western Div., Specification F102-144, Class 4.

9161 Phosphate per TT-C-490, Type I. Prime with zinc chromate primer per TT-P-1757, Color Y. Final film to be light gray semi-gloss enamel per TT-E-529, Color 26373 per FED-STD-595, 2 coats.

9162 Same as 9161, except mask as required by drawing.

9163 Phosphate per TT-C-490, Type I. Prime with zinc chromate primer per TT-P-1757, Color Y. Final film to be light gray semi-gloss enamel per TT-E-529, Color 26440 per FED-STD-595, 2 coats.

9164 Same as 9163, except mask as required by drawing.

9165 Epoxy coating per Barry Data Sheet 983.

9166 Cadmium plate all surfaces, Class 2, Type II, per BPSFW4436 (.0003-.00049 thick) (Bell Helicopter Spec.).

9167 Degrease using perchlorethylene. Spray one coat of Chemlok 205 adhesive following Chemlok Procedure 2020H. Air dry for ten minutes, and spray with one coat of Chemlok 222 adhesive, following Chemlok Procedure 2041.

9168 Chemical film per Bell Process Sheet FW 4182 (similar to Barry 920).

9169 Primer per Vendor P/N 648, and paint with woolsey catalyzed epoxy enamel, (dover gray) Vendor P/N 458. Use with reducer, Vendor P/N 442.

VENDOR: Harry Miller Co.
540 E Street, South Boston, MA 02210
One coat of primer, 0.0005 to 0.002 inch film thickness per TT-P-664. Paint two coats of gray enamel (Formula No. 111) per MIL-E-15090, Type III, Class 2, as continuous film each approximately 0.001 inch thick.

Prime with one coat of zinc chromate primer .3 to .8 mil thick (dry film) per TT-P-1757 composition G, Color Y. Paint with two coats of light gray enamel (Formula III) per MIL-E-15090. Each coat to be approximately 1.0 MIL thick. Enamel Type III, Class 2, baked 30 minutes at 250° F.

Clean with a deoxidizing solution other than caustic dip, and then anodize per MIL-A-8625, sulphuric acid process with a clear water seal. Prime with one coat of zinc chromate primer .3 to .8 MIL thick (dry film) per TT-P-1757 composition G, Color Y. Paint with two coats of light gray enamel (Formula III) per MIL-E-15090. Each coat to be approximately 1.0 MIL thick. Enamel Type III, Class 2, baked 30 minutes at 250° F. Masking required as specified on drawing.

Clean with a deoxidizing solution other than caustic dip, and then anodize per MIL-A-8625, Type II using a clear water seal.

Phosphate treated per TT-C-490, Type I (bonderize or equivalent), after which surface shall be primed with zinc chromate primer, Type I in accordance with the latest version of MIL-P-8585, and finished with black enamel per MIL-E-15090, Class 2.

Same as 9174, except masking required as specified on drawing.

Passivate per QQ-P-35, Type II.

Applies to sub-assemblies using components previously finished per Suffix 808 or 601. Apply wash primer per MIL-P-15328, as a continuous film .0002 to .0005 thick, followed by one (1) coat of zinc chromate primer per MIL-P-8585 applied as a continuous film .0002 to .0010 thick. Apply two (2) coats of gray enamel per MIL-E-15090, Class 2 applied as continuous films approximately .001 thick. Masking required as specified on drawing.

Same as 871, except paint to be light gray baking enamel per MIL-E-15090, Class 2, Type III, color light gray, per FED-STD-595, Color No. 26307.

Phosphate treated per TT-C-490, Type I (bonderize or equivalent), after which surface shall be primed with zinc chromate primer, Type I in accordance with the latest version of MIL-P-8585, and finished with black enamel per FED-STD-595, Color No. 27038.
9180
Same as 9179, except masking required as specified on dwg.

9181
a. Hot dip phosphate treat per TT-C-490, Type I.
b. Prime with one coat of zinc chromate primer .3 to .8 mils thick (dry film) per TT-P-1757, Comp. G, Color Y.
c. Paint with two coats of light grey enamel (Formula #111) per MIL-E-15090, Type II, Class 2, approx. 1.0 mil thick each coat (dry film). Masking required as specified on drawing.

9182
One coat primer per MIL-P-15328. One coat primer per TT-P-1757. Two coats light gray enamel per MIL-E-15090, Type III, Class 2, or Type II, Class 2.

9183
Same as 9182, except masking as specified on drawing.

9184
Hard anodize per MIL-A-8625, Type III, Class 1, .001 to .002 thick.

9185
Same as 9181, except no masking required.

9186
Phosphate treat per TT-C-490, Type II. One coat primer per TT-P-1757, applied as a continuous film .002 to .001 inch thick. Paint two coats light grey enamel per MIL-E-15090, Class 2, applied as a continuous film approx. .001 inch thick.

9187
Same as 9186, except mask as specified on drawing.

9188
Zinc plate per ASTM B633, Class FE/ZN12, Type II. Prime per MIL-P-15328, applied as a continuous film 0.0002 to 0.0005 inch thick, or a hot dip-tank phosphate treatment conforming to Type I of FED Spec. TT-C-490. Follow by one (1) coat of primer per MIL-P-8585 applied as a continuous film 0.0002 to 0.001 inch thick.

Then, (2) two coats of gray enamel, conforming to Class 2 per MIL-E-15090 shall be applied as continuous films approx. 0.001 inch thick.

9189
Finish per Barry Data Sheet 1054.

9190
Finish per Barry Data Sheet 1054, and paint the outside of the flanges of Item 2, with one coat of orange-yellow Lacquer No. 614 complying with MIL-L-19538 (AER).

9191
REVA
Iridite #14-2 per MIL-DTL-5541, Class 1A. Wash prime per MIL-P-15328 .0002-.0005 dry film thickness. Apply one coat of zinc chromate primer per TT-P-1757, .0005-.0008 dry film thickness (color-yellow). Apply two coats of lusterless enamel per TT-E-
527, dark dull grey, Color No. 36231, per MIL-STD-595, .001-.002 dry film thickness each coat. Air dry for 8 hours.

9192 Finish rubber parts per Barry Data Sheet 1054.

Epoxy paint metal parts per MIL-P-23236, Type I, Class 1, or Class 2 (color-black).

a. Wipe steel surfaces clean of grease and oil with a clean rag wet with solvent.

b. Sandblast steel surfaces.

c. Paint the steel surfaces with coating system as required to obtain the number of coats, and a dry minimum total thickness, as specified by each manufacturer listed in the Qualified Products List (QPL 23236).

9193 Prime with zinc chromate primer per TT-P-1757, Color Y. Apply 2 coats of light gray enamel per MIL-E-15090, Class 2, Type III.

9194 Prime surfaces with epoxy polyamide per MIL-P-23377. Apply finish coat of white polyurethane paint per MIL-C-83286, Color 27875 per FED-STD-595. Finish 9195 previously required.

9195 Surface treatment alodine 1200 per MIL-C-81706, Class 1A.

9196 Phosphate dip; prime surfaces with epoxy polyamide per MIL-P-23377. Apply finish coat of white polyurethane paint per MIL-C-83286, Color 27875 per FED-STD-595.

9197 Prime surfaces with one coat epoxy polyamide per MIL-P-23377. Finish 901 previously required. Mask per drawing.

9198 Prime surfaces with two (2) coats of epoxy polyamide per MIL-P-23377. Finish 920 previously required. Mask per drawing.

9199 For inside of ferrous tubes: Clean in accordance with Paragraph 3.5.3 of MIL-E-4158. Finish per MIL-F-14072, Finish No. P215J, Steps 1 & 4.

9200 Clean in accordance with Paragraph 3.5.3 of MIL-E-4158. Recondition and prime per MIL-F-14072, Finish No. P213, Steps 1 & 3. Final paint film F1 in accordance with MIL-F-14072, one coat gray semi-gloss enamel, Color No. 26250, per FED-STD-595.

9201 Same as finish 9200, except mask as necessary.
9202  REVC  Lockheed Martin Cup Paint (23217-All). Caustic etch, chromate conversion per MIL-DTL-5541, Class 1A. One coat of high solids primer per MIL-PRF-23377. Type 1, Class C2, one coat of polyurethane coating per MIL-PRF-85285, Type 1, Class H, Color 17925, white.


9204  Zinc chromate primer per MIL-P-8585. Dull black lacquer per TT-L-20, Color No. 37038, painting to conform to MIL-F-7179 and MIL-F-18264. Masking as required per drawing.

9205  Bell procurement Spec. 4451, Rev. B, "Application of Polyamide Eopxy Primer".


9207  Superseded by Suffix 8022.

9208  Epoxy Primer Class 2, .0005 to .0008 thick per MIL-P-23377, followed by polyurethane coating .0015 to .00225 thick per MIL-C-81773, Color No. 26270 per FED-STD-595. (Mask per drawing).

9209  Zinc phosphate coat per MIL-P-16232, Type Z, Class 2.

9210  Grit blast or wheel abrade. One coat wash primer per MIL-C-8507. One coat zinc chromate primer per TT-P-1757. Two coats of light gray formula III enamel per MIL-E-15090, Type II, Class 2. Masking required as specified on applicable drawing.

9211  Prime surfaces with epoxy polyamide per MIL-P-23377. Apply finish coat of black polyurethane coating per MIL-C-83286, Color 27038 per FED-STD-595. Finish 9195 previously required.

9212  Coarse grit sand blast or equal, and passivate per QQ-P-35. Prime with one coat zinc chromate primer per TT-P-1757. Paint one coat of smooth lusterless (olive drab) green color per TT-E-527 conforming to Color Chip Number 34087 of FED-STD-595. Masking required as specified on drawing.

9213  REVA  Conversion coat per MIL-DTL-5541, Class 1A. Prime with one coat zinc chromate primer per TT-P-1757. Paint one coat of smooth lusterless (olive-drab) green enamel per TT-E-527, conforming to Color Chip No. 34087 of FED-STD-595.
Finish per MIL-T-704, Type A, final coat, Color No. 23, semi-gloss, Marine Corps. green per TT-E-485 and FED-STD-595, as follows:

1. Clean to remove all oil and grease.
2. Zinc phosphate per TT-C-490, Type I.
3. Prime with 1 coat Marine Corps. green enamel, Color No. 23, semi-gloss, 1.0 to 1.5 MILS thick dry film, per TT-E-485.
4. Apply a second coat as final film per Paragraph 3 above.

Same as 9214, except mask as specified on drawing after completing Steps 1 and 2.

Phosphate per TT-C-490, Type I. Paint with 1 coat blue enamel, Color No. 35240 per FED-STD-595. Mask as specified on drawing.


Chemical film per MIL-DTL-5541, Class 1A. Pretreat per MIL-P-15328. Prime one coat primer per MIL-P-23377. Paint with light gray semi-gloss epoxy polyamide per MIL-C-22750, FED-STD-595, Color No. 26307, 0.0254-0.0381 (mm) thick. Masking required as specified on drawing.

Bell Process Spec. 4182 (Rev. E).

Chemical film treatment per Bell Process Spec. 4182. Apply one coat 299-947-060 primer per B.P.S. 4325 to all exterior surfaces with two coats P-95 acrylic lacquer per B.P.S. 4386, color to be light gull gray No. 36440 per FED-STD-595.

Apply one coat of 299-947-060 primer per B.P.S. 4325 to all exterior surfaces (unless otherwise noted) with two coats of P-95 acrylic lacquer per B.P.S. 4386. Color to be light gull gray No. 36440 per FED-STD-595.

Hot dip tank phosphate treatment per Type I of TT-C-490, followed by one coat of primer per MIL-P-8585, applied as a continuous film .0002 thick. Then (2) coats of gray enamel per MIL-E-15090, Class 2, applied as continuous films approx. .001 thick.
9223 Same as 9222, except masking as called out on drawing.

9224 Black adhesive with clear acrylic coating per Data Sheet No. 924.

9225 Apply coating per Data Sheet 1054. Epoxy paint per MIL-P-23236, Type I, Class 1, or Class 2 (color-black) exposed steel surfaces as follows:

A. Wipe steel surfaces clean of grease and oil with a clean rag, wet with solvent.

B. Sandblast steel surfaces.

C. Paint the steel surfaces with coating system, as required, to obtain the number of coats, and a dry minimum total thickness as specified by each manufacturer listed in the Qualified Products List (QPL 23236).

9226 A. Hot dip phosphate treat per TT-C-490, Type I.

B. One coat primer 0.8 mils (min.) thick (dry film) per TT-P-636.

C. One coat green paint per TT-E-529, Color No. 24533 per FED-STD-595. 0.0254-0.0381 MM (.001 -.0015 mils) thick dry film.

D. Masking required as specified on drawing.

9227 Oil resistant coating per Data Sheet 915.

9228 REV B Passivate per AMS2700, Types 2 or 6 (Superceded QQ-P-35, Types I, II, III OR VI).

9229 Phosphate dip per TT-C-490, Type I, and prime with zinc chromate primer per TT-P-1757, Color Y.

9230 Organic pretreatment coating per TT-C-490, Type III.

9231 Aluminum conversion coating (clear) per MIL-DTL-5541, Class 3.

9232 Finish per Barry Data Sheet 1163.

9233 Electropolish per Barry Spec. F102-144, Type IV. Silver plate per QQ-S-365A, Type III, Grade A, only the surfaces specified on the drawing.

9234 Chromate conversion coating per Data Sheet 988. One coat of epoxy primer per B.P.S. FW 4451.
1) Aluminum conversion coat per MIL-DTL-5541, Class 1A.

2) Prime one coat primer per MIL-P-23377.

3) Paint one coat gray lusterless enamel per MIL-C-83286. Color to be No. 36251 per FED-STD-595.

4) Mask as called for on drawing.

Hard anodize .002 thick per MIL-A-8625, Type III, Class 2, color-flat black. Masking required, if specified on drawing.

REVA Chemical film per MIL-DTL-5541, Class 1A. Paint outside gray lacquer per MIL-L-7178.

Black lusterless paint. Masking as required per drawing.

Degrease and coat with sage green polyester coating powder to a nominal thickness of 2 mils. Threads to be free of coating. (Applied by Technical Powder Coating, RD #3, Old Denver Road, Denver, PA 17517).

A) Aluminum conversion coat per MIL-DTL-5541, Class 1A.

B) Prime one coat primer per MIL-P-23377.

C) Mask as specified on drawing.

Zinc chromate primer per MIL-P-8585, Color Y. Paint 2 coats dull black enamel per TT-E-527, Color No. 37038 per FED-STD-595. Masking, if required per drawing.

Black semi-gloss enamel, Color No. 27038 per FED-STD-595.

Black oxide per MIL-C-13924, Class 4.
9244 P513-2 of MIL-F-14072 as follows:

(1) Aluminum conversion coat per MIL-DTL-5541, Class 1A.

(2) Pretreatment coating per MIL-P-15328.

(3) Prime with one coat of zinc chromate primer per TT-P-1757.

(4) One coat green paint per TT-E-529, Color No. 24533 per FED-STD-595, 0.0254 - 0.0381 MM (.001 - .0015 mils) thick dry film.

9245 Black oxide per MIL-C-13924, Class 1.

9246 REVA Dark green semi-gloss enamel, Color No. 24084 per FED-STD-595.

9247 REVA Finish per MIL-T-704, Type A. Final coat lusterless enamel, forest green per MIL-E-52798, Type II.

(1) Clean to remove all oil and grease.

(2) Zinc phosphate per TT-C-490, Type I.

(3) Prime with one coat forest green lusterless enamel, 1.0 to 1.5 mils thick dry film per TT-E-527.

(4) Apply second coat as final film per Paragraph 3 above.

Mask as specified on drawings, after completing Steps 1 and 2.

9248 Phosphate per TT-C-490. Prime and paint with primer and synthetic resin supplied by customer. Air dry only at least 24 hours. Protect from contamination during air dry.

9249 Same as 871, except phosphate treat after grit blasting. Masking as required.

9250 Paint using glossy black enamel (FED-STD-595, Color Chip # 17038). Mask as required per drawing.
9251 Finish rubber parts per Barry Data Sheet 915. Epoxy paint metal parts per MIL-P-23236, Type I, Class 1 or Class 2 (color-black).

A. Wipe steel surfaces clean of grease and oil with a clean rag, wet with solvent.

B. Sandblast steel surfaces.

C. Paint the steel surfaces with coating system, as required, to obtain the number of coats, and a dry minimum total thickness as specified by each manufacturer listed in the Qualified Products List (QPL 23236).

**CAUTION:** Required when mixing or applying per Data Sheet 1155.

9252 Phosphate dip per TT-C-490. Apply one coat of primer per TT-P-1757. Apply two coats dark blue semi-gloss enamel (FED-STD-595, Color Chip No. 25053). Mask threads.

9253 Prepare and prime with finish P210-1 of MIL-F-14072: Reconditioning:

Sanding or abrasion or phosphoric acid etch per MIL-C-15078;

Pretreatment per MIL-P-15328;

Prime per MIL-P-23377;

Final paint film: forest green, urethane;

Paint per MIL-C-46168. Film thickness shall be .001 to .0015.

9254 Sand, abrade or phosphoric acid etch per MIL-C-10578. Pre-prime per MIL-P-15328. Prime per TT-P-1757, .004 -.006 thick. Final film, Gray #26152 per FED-STD-595, semi-gloss enamel per TT-E-529, .0010 -.0015 thick.

9255 Electropolish per Western Division Specification F102-144, Class III.

9256 Coat specified area with Karon RP BV Kamatics. Thickness to be .009 -.013 per side. Wear material to be in accordance with MIL-B-8943. Other surfaces to be anodized per MIL-A-8625, Type II, Class 1.

9257 Specified surface to be hard anodized to MIL-A-8625, Type III, .002 inches & Teflon impregnated. Mask other surfaces then iridite per MIL-DTL-5541, Class 1A (no caustic).
One coat phosphate treatment per TT-C-490, Type I. One coat of zinc chromate primer .0004 to .0006 thick (dry film) per TT-P-1757. Paint with one coat of semi-gloss enamel per TT-E-529, Color Chip 26293 per FED-STD-595. Total thickness of paint and primer .005 max.

Finish for GCA Serva Benches (Reserv. by HVH 3/12/82).

Passivate per MIL-STD-171 (MR) Finish No. 5.4.1 (BS 901). Apply Lub-Lok 5306 to threads per F65A GL1 (MIL-L-8937).

Aluminum conversion coat per MIL-DTL-5541, CL 1A. 2 coats yellow zinc chromate primer per TT-P-1757. 1 coat medium gray enamel per TT-E-529, Color No. 26231 of FED-STD-595.

Phosphate treat per TT-C-490, Type I or grit blast. Prime with zinc chromate primer per TT-P-1757, Color Y and finish with light gray enamel per MIL-E-15090, Class 2. (2 coats of enamel). Color No. 26307 per FED-STD-595.

Zinc chromate primer, Color Y (yellow primer) composition L per TT-P-1757, apply per MIL-P-6808. Paint per TT-E-529, Type I, Color No. 24533 (light green) per FED-STD-595.

Metal pretreatment coating per MIL-C-8514. Wash primer per MIL-C-8507 followed by epoxy polyamide primer per MIL-P-85582, Type I and finish coat of polyurethane per MIL-C-85285. Color No. 26270 per FED-STD-595 applied per MIL-F-18264.

One coat epoxy polyamide primer per MIL-P-23377, Class 1 or 2. Followed by two coats of aliphatic polyurethane coating per MIL-C-46168, Color-flat olive drab, applied in accordance with MIL-F-18264. Masking as required on drawing.

One coat epoxy polyamide primer per MIL-P-23377, Class 1 or 2. Followed by two coats of aliphatic isocyanate urethane coating per MIL-C-83286, Type I, Color gray No. 26307 per FED-STD-595. Masking as required on drawing.


Passivate by immersing in a 50% (by volume) nitric acid solution for 15 mins. Rinse and dry after passivation.
9269  Passivate per MIL-STD-171 (ORD) Finish No. 5.4, after which threads to be silver plated per AMS 2411, 0.0003 - 0.0006 thick, other areas optional.

9270  Finish shall be applied by a Sikorsky Aircraft approved source for special processes and laboratories per Sikorsky Specification SS 8486.

9271  Passivate per QQ-P-35 in accordance with Martin Marietta Specification EDS 30184, and to be applied by Martin Marietta approved sources only.

9272  Zinc phosphate per TT-C-490, Type I. 1 coat epoxy primer per MIL-P-52192, film thick .80 MIL-.120 mil. 2 coats forest green enamel per MIL-E-52929, film thick .90 mil min. per coat.

9273  One coat zinc chromate primer per MIL-P-8585. Two coats black semi-gloss enamel per TT-E-489, Color 27038 per FED-STD-595, and bake 1 hour at 275°F. Mask as required on drawing.

9274  Zinc chromate primer per MIL-P-6889. Lusterless gray paint, Color No. 36231 per FED-STD-595. Marking per drawing.

9275  Passivate per QQ-P-35, Type III.

9276  Finish per Barry Data Sheet 1398.

9277  See Barry Data Sheet 1407, Paint No. 053711-6015025-203 (dark blue).

9278  REVA  Chemical film per MIL-DTL-5541, Class 1A. Paint black polyurethane coating per MIL-C-83286. Color Number 27038 per FED-STD-595.


9280  See Barry Data Sheet 1407, Paint No. 053711-6015025-201 (light blue).

9281  REVA  Aluminum conversion coating per MIL-DTL-5541, Class 1A and then apply one coat of primer (conforming to TT-P-1757, Composition L, Color Y) .0006 -.0008 thick dry film, followed by two coats of light gray enamel (conforming to MIL-E-15090, Class 2, Type III) approximately .001 thick dry film per MIL-E-16400.

9282  REVA  Electroless nickel plated in accordance with MIL-C-26074, Class 4, Grade A or equivalent per AMS2404.
Phosphate treat per TT-C-490, Type I or grit blast; Class 1A. Apply primer per MIL-P-53030 water reducible epoxy: 1.0 mils minimum dry film thickness.

REVA Chemical film, chromate per MIL-DTL-5541, Class 1A. Prime (.0004 - .0006) per MIL-P-8585, Color Y. Apply two coats (.0009 - .0012 each) per TT-E-529 CL B, Color No. 24084 per FED-STD-595. Requirement of Sec. 6, MIL-STD-171 shall apply.

Passivate per Bell Process Sheet FW4007 or MIL-S-5002.

Black oxide per MIL-C-13924, Class 3.

Caustic etch; one coat primer per MIL-P-23377. Masking required when specified on drawing.

Clean and degrease thoroughly; prime with zinc chromate. Spray with cloud white epoxy paint, one coat. Bake for 15 min. at 300°F.

Chemical film per MIL-DTL-5541, Class 1A. Grey lacquer exterior per TT-L-32.

Pretreat, prime and paint per MIL-DTL-14072 finish P211.1 color AG. Total final finish thickness .004 inch to .006 inch.

See Barry Data Sheet 1451, paint 053711-6020644-201 (light blue).

Abrasive clean per TT-C-490, Method 1. Apply one coat of MIL-P-23377 primer, and two coats MIL-C-83286 polyurethane per MIL-F-18264. Top coat shall be Color No. 15045, strata blue, per FED-STD-595. Do not abrasive clean or paint the rubber.

Step 1: Anodize per MIL-A-8625, Type II. Step 2: Apply one coat of primer per MIL-P-85582, Type I (Mask as required per drawing). Certification per Hamilton Standard H.S. 3197 required.

Passivate per QQ-P-35. Apply one coat of primer per MIL-P-23377, Type II. (Mask as required per drawing).

Black anodize per MIL-A-8625, Type I, Class 2. Plating thickness to be .0002 to .0003.
9296 REVA Electroless nickel plated in accordance with MIL-C-26074, Class 4 or AMS2404. Plating to be .0004 to .0005 thick.

9297 Tin plate per MIL-T-10727, Type I, .0002 ± .00005 thick.

9298 Prime surfaces with epoxy polyamide per MIL-P-23377, Type I. Apply finish coat of gloss white polyurethane coating per MIL-C-83286, Type I, Color 17925 per FED-STD-595.

9299 Prime with one coat of zinc chromate primer per TT-P-1757. Apply one coat of lusterless olive green enamel per TT-E-527, Color #34097 per FED-STD-595.

9300 Chemical conversion coating per MIL-DTL-5541, Class 1A. Apply finish per MIL-F-14072, Type I, Finish No. P510.2. Apply one coat of epoxy polyamide primer per MIL-P-23377, Class 1 to a dry film thickness of .0006 to .0009. Apply two coats of alkyd lusterless enamel per FED. Spec. TT-E-527. Each coat .001 thick minimum, color-blue gray, No. 36231 per FED-STD-595. Masking as required per drawing.

9301 Phosphate treat per TT-C-490, Type I or grit blast, Class 1A. Apply primer per MIL-P-53030, water reducible epoxy: 1.0 mils min. dry film thickness.

Paint with high solids, polyurethane (voc. content less than 3.5 pounds per gallon).
Color: gray, semi-gloss, fine texture No. 26293 per FED-STD-595. 1.0 mil dry film thickness.

Approved Paint Manufacturers:
Cardinal Industrial Finishes, San Jose, CA,
Tel.: (408) 292-6732.

Sherwin Williams, Chicago, IL, Tel.: (800) 621-2805.

9302 Zinc chromate primer per MIL-P-6889. Paint with high solids, polyurethane (voc. content less than 3.5 pounds per gallon). Color: gray, semi-gloss, fine texture No. 26293 per FED-STD-595. 1.0 mil dry film thickness.

Approved Paint Manufacturers: Cardinal Industrial Finishes, San Jose, CA,
Tel.: (408) 292-6732.
Sherwin Williams, Chicago, IL,
Tel.: (800) 621-2805.
9303 Clean and passivate per MIL-S-5002.


9305 REVA 1. Clean assembly thoroughly prior to paint(do not passivate). 
2. Mask as indicated on drawing. 
3. Apply one coat of primer per MIL-P-23377, Type II.

9306 Phosphate treat per TT-C-490, Type I. 1 coat of primer IAW TT-P-1757 to be applied as a continuous film .0002 to .001 thick. Paint with 2 coats of grey enamel per MIL-E-15090, Class 2. Each coat to be applied as a continuous film approximately .001” thick.

9307 Conversion coat per MIL-DTL-5541, Class 1A. One coat of zinc chromate primer per MIL-P-6889. Paint with two coats of gray enamel paint per MIL-E-15090, Class 2. Each coat to be applied as a continuous film approximately .001 thick.

9308 One coat primer per MIL-P-15328; one coat primer per TT-P-1757, and two coats light gray enamel per MIL-E-15090, Type III, Class 2 or Type II, Class 2. Masking or other qualifications as per drawing.

9309 See Barry Data Sheet No. 1514.

9310 REVB Electroless nickel plate, .0002 - .0003 thick per AMS2404.

9311 Hard anodize, 0.002 thick per MIL-A-8625, Type III. Prime with one coat of zinc chromate primer per TT-P-1757. Paint with one coat of blue enamel per TT-E-527, Color 35109.

9312 Paint thermalux, Type 270, low sheen black.

9313 Same as 9036, except paint thickness to be .001 to .003 thick.

9314 REVA One coat epoxy primer per MIL-P-23377, Type I. One coat gray epoxy enamel per MIL-C-22750, Color #36231 per FED-STD-595. Mask as required per drawing.

9315 Nickel plate per AMS 2424, .0002 - .0005 thick.

9316 "Clean assembled part using room temperature, acidic based cleaning solutions only. Alkalai cleaners or temperature elevation during cleaning is not allowed. Rinse thoroughly with water, and bake part, if necessary, to avoid bleeding”. Aluminum conversion coat per MIL-DTL-5541,
Class I. Paint per MIL-P-23377, Type I. Apply two coats specified coating per MIL-F-18264, using MIL-C-83286, form kit, Type I, FED-STD-595, Color 37925.

9319 REVB  Electroless nickel plate .0005 minimum thick per MIL-C-26074, Class 1, Grade B, or equivalent per AMS2404, except no relief bake at 375° F per Section 3.4.1 allowed.

9320 REVC  Electroless nickel plate .0015 minimum thick per MIL-C-26074, Class 1, Grade C, or equivalent per AMS2404, except no relief bake at 375° per Section 3.4.1 allowed.

9321  See Barry Data Sheet No. 1569. Sherman Williams Buehler White Catalyst 6-1 ratio V-66-V-67.

9322 REVB  Paint per MIS-20007(Latest Revision) Type I, Condition B, Grade 2 except paint thickness check on interior holes and cutouts in rail not required. Per MIS-20007, drawing dimensions apply before paint. Painting must be performed by MIS-20007 approved supplier as MIS-20007 is a restricted document and can not be distributed by Barry Controls. Latest Revision status of MIS-20007 shall be Provided with Purchase Order.

9323  Chemical conversion coating per MIL-DTL-5541, Class 1A. Paint per TT-E-527, Color 36231 per FED-STD-595. Mask as required on drawing.

9324  Prime per MIL-P-23377, Type I. Apply two coats specified coating per MIL-F-18264 using MIL-C-83286, form kit, Type I, FED-STD-595, Color 37925. Masking as required on drawing.

9325  Passivate per QQ-P-35, Type I.

9326  Clean and passivate in accordance with ASTM A380-78.

9327  Grit blast, treat with zinc phosphate per TT-C-490. Prime with zinc chromate primer per TT-P-1757, Color Y. Finish with light gray enamel per MIL-E-15090, Type II, Class 2 (2 coats).

9328 REVA  Passivate per MIL-STD-171, finish 5.4.1, then electroless nickel plate .0005 - .0007 thick per MIL-C-26074, Class 1, Grade B or equivalent per AMS2404.

9329  a)  Clean per MIL-T-704 or equivalent.

9330  Wash prime IAW DOD-P-15328. Apply zinc chromate primer to metal surfaces IAW TT-P-1757, TY OPT, Color Y. Coat threads with castor oil IAW MIL-C-1517.
Prior to painting, apply one coat of pretreatment coating per DOD-P-15328 .0004 to .0006 mils thickness.

Paint three coats of epoxy polymide paint in accordance with MIL-P-24441 in the following order:

1. Prime: 3 to 4 mils coat of Formula 150 per MIL-P-24441/1.
2. Second coat: 3 to 4 mils coat of Formula 155 per MIL-P-24441/6.
3. Top coat: 2 to 3 mils coat of Formula 151 per MIL-P-24441/2. Total dry film thickness shall be 7 to 9 mils minimum.

Coarse grit sand blast or equal and passivate per MIL-F-14072, finish Number E300.

Passivate per QQ-P-35, then apply one coat of primer per MIL-P-23377, and two coats of enamel per MIL-C-22750, Color No. 36231 of FED-STD-595. Mask as indicated on the drawing.

Passivate per QQ-P-35, Type IV. Prime with one (1) coat (.0005 to .001 thick) of zinc chromate primer per TT-P-1757, Color Y and finish with two (2) coats of gray enamel, conforming to Class 2 of MIL-E-15090, shall be applied as a continuous film, approximately .001 inch thick.

Prime and finish sand yellow, Color No. 23448, per FED-STD-595, in accordance with MIL-T-704, Type A and TT-E-485, Type II.

Phosphate treat per TT-C-490, Type I. Prime with zinc chromate primer per TT-P-1757, Color Y and finish with light gray enamel per MIL-E-15090, Type II, Class 2 (two coats enamel). Color No. 26307 per FED-STD-595.

Wash primer per MIL-P-15328. Zinc chromate primer per TT-P-1757. Paint with two coats lusterless black, paint Color No. 37038 per FED-STD-595.

Passivate per QQ-P-35, Type VI or VII.

Chem. film IAW MIL-DTL-5541. Prime and paint IAW MIL-E-16400, Para. 3.4.11.3.5.

Prime in accordance with MIL-P-23377. Paint forest green per MIL-C-46168.

Olive drab cadmium plating, M225 per MIL-F-14072.
Painted with chemical agent resistant coating (CARC), Finish 20.24.1 per MIL-STD-171, in color green 383.

REVA Caustic dip per Barry Finish 909.

Coarse grit blast entire part, then passivate per QQ-P-35.

See Barry Data Sheet No. 1677.

REVA Electroless nickel plate per MIL-C-26074, Class 2, Grade A or equivalent per AMS2404.

One coat Zinc Chromate Primer .3 to .6 mils (dry film) thk. per MIL-P-8585.

Black oxide coating per AMS 2485.

Two coats epoxy polyamide primer per MIL-P-23377, Type II. Followed by a final paint film of aliphatic polyurethane coating per MIL-C-46168, color olive drab (color 34094, 34097, or 34128 per FED-STD-595). Thinner for primer or topcoat shall be per MIL-T-81772, Type I.

Paint in accordance with OD 15309 (System 16), light gray and finish with OD 16249, Class III.

Aluminum conversion coat per MIL-DTL-5541, Class 1A. Paint per WS 19201, Group A, Type I or II* (see below). Apply three (3) coats of epoxy polyamide paint in accordance w/MIL-P-24441 in the following order:

**TYPE I**

1). Primer:
   (Approx. 3 - 4 mils)Formula 150

2). Second Coat:
   (Approx. 3 - 4 mils)Formula 151

3). Top Coat:
   (Approx. 3 - 4 mils)Formula 152

** Final dry-film thickness should be between 8 and 24 mils.

** Individual coats of epoxy polyamide are not interchangeable between type callout.
One coat of polysulfide primer per MIL-P-23377 Type 1.
One top coat of polyurethane coating per MIL-C-83286, Type 1 color 17038 or 37038 per FED-STD-595.

Electroless nickel plate per MIL-C-26074 Class 1, Grade A or equivalent per AMS2404.

Finish:
Clean: IAW TT-C-490 Method Optional.
Pretreat: IAW TT-C-490, Type I, Class Optional or type III.
Prime: IAW MIL-STD-193, Option: Prime IAW MIL-P-53084 (Dry Film Thickness .023 - .035mm) or GM9984017 or GM9984070.
Topcoat: IAW MIL-C-46168 or MIL-C-53039 Color #383 green IAW FED-TD-595 Dry film thickness IAW MIL-STD-193

Chemical film per MIL-DTL-5541 class 3, color yellow, prime surface per TT-P-1757 finish light gray enamel per MIL-E-15090 Class II one coat.


B). Chromate conversion coat IAW MIL-DTL-5541, Class 3 on all remaining surfaces including holes and threads.
Note: Sequence of coating is optional.

Impregnated per MIL-STD-276 Method B using impregnates per MIL-I-17563 Class 1.

Treat per MIL-DTL-5541 Class 1A followed by primer coating, epoxy per MIL-P-23377, 1.0 mils min. dry film thickness and finish coat, epoxy per MIL-C-22750 color No. 34088 per FED-STD-5958 1.0 Mils min. dry film thickness.

Clean part in a bath of 20% nitric acid and 3% hydrofluoric acid at a temperature of 125°F followed by a clear water rinse.

After all machining and welding operations are completed, rust or other corrosion products and flux shall be removed by abrasive blasting, sanding, wire brushing, or other mechanical means. Surfaces shall be cleaned of all grease, oil, and dirt by solvent wiping and rinsing, vapor degrease, or caustic wash followed by rinsing. Operator shall verify cleaning quality prior to release to next operation – No Contamination Permitted.
Pretreat with TT-C-490, Type II or III. Use of DOD-P-15328 to meet TT-C-490, Type III is authorized.

-OR-

Zinc plate per ASTM B633, SC3, Type II, Clean per TT-C-490, Method 2.

Then apply one coat of primer in accordance with formula 150 per MIL-P-24441/20. The primer shall have a dry film thickness of 3-4 mils. Then apply two continuous film coats of enamel in accordance with MIL-DTL-15090 Type II or III, CL2. Each coat shall have a minimum thickness of .001 inches. Dry film thickness orange peel shall be kept to a minimum. Acceptable amounts of orange peel shall be specified by procuring activity.

*CAUTION: For MIL-P-24441/20 and MIL-E-15090 Type II Coating System, Force Drying or Baking in Oven is Prohibited.


9362 REV B Apply one coat of epoxy polyamide primer per MIL-PRF-23377, dry film thickness of 0.06 - 0.9 mils. Top coat shall be aliphatic polyurethane coating per MIL-DTL-53039B, Fed color 34094, equivalent to CARC 383, green. (MIL-C-46168 has been superseded). Top coat dry film thickness 1.8 to 2.4 mils. Thinner for top coat shall be per MIL-T-81772, Type 1.

9363 REVA After all machining and welding operations are completed, rust or other corrosion products and flux shall be removed by abrasive blasting, sanding, wire brushing, or other mechanical means. Surfaces shall be cleaned of all grease, oil, and dirt by solvent wiping and rinsing, vapor degrease, or caustic wash followed by rinsing.

Pretreat with TT-C-490, Type II or III. Use of DOD-P-15328 to meet TT-C-490, Type 3 is authorized.

Then apply one coat of primer in accordance with formula 150 per MIL-P-24441/1. The primer shall have a dirt film thk of 3-6 mils. Then apply two continuous film coats of enamel in accordance with MIL-E-15090 Type II or III, CL2. Each coat shall have a min. thk of .001 inches. Dry film thk orange peel shall be kept to a min. acceptable amounts of orange peel shall be specified by procuring activity.

9364 Chromate conversion coat per MIL-DTL-5541, Class 1A. One coat zinc chromate primer, .0002-.0010 thick per TT-P-1757, Color Y, two coats tan enamel per MIL-E-15090, .001 thick, Class 2, Type III.

9365 MIL-E-15090, Formula 3, Class 2, Type III.
9366 REVA  Al conversion per MIL-DTL-5541, Class 1A. Primer per MIL-P-53022. Finish per MIL-C-46168, color olive drab (Color 34094, 383 epoxy coating).

9367  Silver Plate per AMS 2411, .0003-.0006 thick.

9368 REVA  1. Zinc - Plate per ASTM B633, FE/ZN8, Type II.
2. Clean per TT-C-490, Method II.

9369  Finish: Zinc Plate with Chromate Overcoat, Color matte olive drab per ASTM B633, Type II, FE/ZN 8 or ASTM B695 Type II, Class 8, or DIN 267 A3D.

9370  Passivate per QQ-P-35, type optional. Application of coatings shall be in accordance with MIL-F-14072. Apply primer per MIL-P-53022. Apply top coat per MIL-C-46168 type optional, green, 383 (34094). Alternate top coat: MIL-C-53039 green, 383 (34094).

9371  1). Apply one coat of primer per MIL-P-23377, Type II.
2). Apply final paint film per MIL-C-46168, Green 383 (Color 34094 Per FED-STD-595).

9372  Passivate per QQ-P-35 dry film lube per M46010 Type I.

9373 REVA  Part A: Paint with one coat of black epoxy baking primer. Following application, cure for 15 minutes at 400°F. (This is epoxy baking primer series #9734 available from: Raffi and Swanson, Inc., 100 Eames St., Wilmington, MA 01887

or

Part B: Paint with one coat of black polyurethane, min. dry film thickness 1.5 mil, Eastern ChemLac Urachem, W5055 with exterior catalyst R1100. Thin with solvent R1200. Mix 4-1-1 (adjust thinner as required, consult ECL for thinner greater than 1 part for VOC compliance). Cure 16 hours at room temperature or force for 15 minutes at 150°F to 200°F. Material available from Eastern Chem-Lac, 1100 Eastern Avenue, Malden, MA 02148.

9374  Black oxide per MIL-C-13924, Class 1 without supplementary preservative treatment.

9375 REV A  Zinc plate per ASTM B633 Type II - FE/ZN 12, Type II Black Dichromate.

9376  Sherwin Williams Formula No. F63JXW0445, Color Off-White.

9377 REV A  Industrial E-Coat: Color - Black; Cathodic Epoxy Material. 0.4 mil minimum thickness to meet 96 hour salt spray per ASTM B117. (Note: This finish requires curing at temperatures above 300°F.)
If rubber mounts are to be coated, curing times should not exceed the following to avoid post-cure changes to the rubber:

- 300°F - 20 minutes max.
- 350°F - 10 minutes max.

Note: This finish meets FMTV requirements per US Army Drawing 12420325, Method 7.

9378 REVB  Mil-C-26074, Electroless Nickel, Grade B .0002 to .0005 or equivalent per AMS2404. Acceptable alternative finish:
Nickel Plate IAW QQ-N-290 Class 1 Grade F.

9379  Anodize per HS 334 Type II, Class 2, Non Reflective Gray with Nickel Acetate Sealant.

9380  Finish per MIL-C-81706, Class 3.

9381  Nickel Plate .0002 - .0004 thick with a .000025 min. thick black chrome flash.

9382  Hard anodize and seal IAW MIL-A-8625, Type III, CL1, .002 ± .0005. The water seal shall consist of boiling parts in deionized water for a minimum of 30 minutes.

9383  Caustic dip per Barry 909, followed by aluminum conversion coat per Barry 920, and apply one coat of #27038 black epoxy polyamide coat. Smooth finish, bake at 200°F for 1 hour.

9384  Caustic dip per Barry 909, followed by aluminum conversion per Barry 920, and apply one cost of Sherwin Williams #F63TXW1440 polane “T”. Smooth finish, bake at 200°F for 1 hour.

9385 REVA  Clear chromate, power coat, hybrid, smooth finish 20° - 30° mat, color Tiger DryLac - RAL 9002, off white.

9386 REVA  Clear chromate, power coat, hybrid, smooth finish 30° - 40° semigloss, color Morton Corvel 70-2015, Raven black.

9387 REVA  Clear chromate, powder coat, hybrid, smooth finish 30° - 40° semigloss, Motron Corvel 40-7044, gray.

9388  After all machining and welding operations are completed, rust or other corrosion products and flux shall be removed by abrasive blasting, sanding, wire brushing, or other mechanical means. Surfaces shall be cleaned of all grease, oil, and dirt by solvent wiping and rinsing, vapor degrease, or caustic wash followed by rinsing.
Pretreat with TT-C-490, Type II or III. Use of DOD-P-15328 to meet TT-C-490, Type 3 is authorized. Then apply one coat of primer in accordance with TT-P-645, Color Y. The primer shall have a dry film thickness of 3-6 mils. Then apply two continuous film coats of enamel in accordance with MIL-E-15090 Type II or III, CL2. Each coat shall have a minimum thickness of .001 inches. Dry film thickness orange peel shall be kept to a minimum. Acceptable amounts of orange peel shall be specified by procuring activity.

9389 Passivate per Hamilton Standard SVHS 12545 Type II. (Abrade surface using 80 grit paper, passivate using solution concentration and time listed.) To be performed by Hamilton Standard approved sources only.

9390 Silver plate .0002 - .0006 thickness, per QQ-S-365, Type I, Grade B.

9391 Anodize per Hamilton Standard specification HS 334 Type II, Class 1. To be performed by Hamilton Standard approved sources only.

9392 Black urethane texture- 4 part paint, 1 part catalyst.


9394 Light yellow dichromate.


9396 Hard anodize per MIL-A-8625, Type III, Class 1.

9397 Prime per TT-P-645 or TT-P-664, one coat dry film thickness of .0006 to .0008 thick zinc-molybdate, alkyd. Apply 2 coats .001 inch minimum dry film thickness each coat of light gray formula #III, Type III, Class 2. Paint per Mil-E-15090. Mask as indicated on drawing.

9398 Grit Blast, treat with zinc phosphate per TT-C-490. Prime with epoxy-polyamide green primer per MIL-P-24441/20. Finish with grey epoxy-polyamide paint per MIL-P-24441/27 color 26307 per FED-STD-595.
Passivate Per QQ-P-35, Type VI.

Finish all exposed aluminum surfaces as follows:

a) Aluminum conversion coat (gold).
b) Pretreat primer per MIL-P-53022.
c) Corrosion inhibiting epoxy primer per DOD-P-23377, .001-.0015 thick.
d) Green 383 Carc paint per MIL-C-46168, .0018-.005 thick.
e) Mask ALL elastomer sections prior to finishing.

Zinc plate per ASTM B633, Class FE/ZN 12, Type II. Prime with zinc chromate primer per TT-P-1757, Color Y, and finish with light gray enamel per MIL-E-15090, Type II, Class 2 (2 coats of enamel), Color No. 26307 per FED-STD-595.

Anodize per Mil-A-8625, Type II, Class 2. Color: Black Number 37038 per FED-STD-595.

Dikronite coat IAW DOD-L-85645, Type I.

Primer shall be one coat dry film thickness of .0006 to .0008 thick per TT-P-645 or TT-P-664. Paint shall be light grey color 23607 per FED-STD-595, applied in two continuous film coats, in a minimum of .0010 each per MIL-E-15090, Class 2.

Sealed anodized coating per MIL-A-8625, Type 3 Class 2, Dye color white.


Black Electrocoat, Commercial Quality.

Epoxy polyamide primer, .0005 to .0008 thick per MIL-P-85582, Type 1, followed by two coats of polyurethane coating .0015 to .0025 thick total per MIL-C-81773, Color No. 26270 per FED-STD-595. (Mask per drawing). Coating thickness to be verified by process surveillance.

Zinc Plate per ASTM B633, Class FE/ZN8, Type II. To reduce the risk of hydrogen embrittlement, carefully follow the requirements of ASTM B633 related to heat treatment time and temperature based on the physical properties of the stud.
9410 REVA  Electroless Nickel in Accordance with MIL-C-26074, Class 4, or equivalent per AMS2404, .0004 - .0006 inch thickness.

9411 REVA  Clean and Phosphate dip. Mask as required per drawing. Apply one coat zinc chromate primer per MIL-P-8585.

9412  Black chromate.

9413  Nitro-Tec S surface treatment, .0005 to .002 depth, surface finish 12 - 16 RMS.

9414 REVA  Chem Film IAW MIL-DTL-5541 Class 3, Primer MIL-P-53022 Type 2 Top Coat MIL-C-85285 Type 1, Color Fed Std 595 #26270 Haze Gray.

9415  Black Zinc Chromate .0002/.0004.

9416 REVA  Electroless nickel flash plate (for hole coverage) per 1.4.3.1 of MIL-SST-171, Class 1, .0001 inch thickness, followed by Zinc plate per 1.9.2.2, of MIL-STD-171 Class 2, .0005 inch thickness.

9417  Passivate per QQ-P-35 (Barry finish No. 901) followed by black oxide per MIL-C-13924, Class 4 (Barry finish No. 9243). Previously passivated parts may be used and do not require re-passivation.


9419 REVA  Hard anodize per MIL-A-8625, Type III, Class 1, .0008 to .0012 inch thick. Seal with hot deionized water, 140ºF to 180ºF for 30 minutes minimum.

9420 REVA  Hard anodize per MIL-A-8625, Type III, Class 1, .0016 to .0024 inch thick. Seal with hot deionized water, 140ºF to 180ºF for 30 minutes minimum.

9421  Phosphate coat with Turco Paintite or equal. One coat Eastern Chem-Lac Inc. Industrial Lacquer #W8089, (red). Masking as per drawing.

9422  Apply primer per MIL-PRF-85582, Type II, Class C2 or MIL-P-23377, Type II, Class C, dry film thickness 0.6 to 0.9 mils. Apply topcoat per MIL-PRF-85285, Type I, lusterless grey color no. 36495 per FED-STD-595, dry film thickness 1.7 to 2.3 mils.

9423  Black finish with zinc phosphate pre-treatment. Single coat with minimum dry film
thickness of 15 micrometers (0.0006 in). Performance requirements of 250 hrs salt spray (ASTM B117-97) with 1.5 mm (0.06 in) maximum creepage. Adhesion 90% minimum (ASTM D3276-96).

9424 Zinc plate per ASTM B633, FE/ZN 8, Type I.

9425 Aluminum conversion coating per MIL-DTL-5541, Class 1A (color per drawing and applicable color chips). Color to be yellow unless otherwise specified. This finish is same as 920.

9426 Apply one coat of primer in accordance with formula 150 per MIL-P-24441/1. The primer shall have a dry film thickness of 3-6 mils. Then apply two continuous film coats of enamel in accordance with MIL-E-15090 Type II or III, CL2. Each coat shall have a minimum thickness of .001 inches. Dry film thick orange peel shall be kept to a minimum. Acceptable amounts of orange peel shall be specified by procuring activity.

9427 Prepare metal surface and apply adhesive bonding system per drawing or Barry Controls Data Sheet.


9429 REVB Electrostatic spray using Dupont Powder Coatings, Product Name: Bead Blast Silver Color Number: PFA204B1. Pretreat with Bonderite 1000. Final cured thickness to be 2.5 to 3 mils. Cure at 450°F metal temperature for 15 minutes.

Finished product must comply with Harley-Davidson Motor Company General Engineering Standard 07011. Vendor must submit first article PPAP samples per sections 5.1 thru 5.5, 5.9, and 5.11. Vendor must submit samples per sections 5.1 thru 5.3 with each production lot.

9430 All structural components shall be cleaned per SSPC SP-3 and coated with one touch up coat and one full coat of Zinc Molybdate Primer, TT-P-645 or equal. Then paint with two coats of Imperial Chemical Industries ICI DEVOE DEVFLEX 4208-9800 Safety Blue Waterborn Acrylic Enamel Paint (EB Part Number 218022606) or Equal. Color to be equal to color chip 15123 as shown in Federal Specification 595.
9431 One coat Sherwin Williams Fast Production Enamel or equivalent finish. The product shall meet the requirements for a 96 hour salt spray IAW ASTM B117 and evaluated IAW ASTM D1654 Procedure B, Table 2, less holes and interior surfaces of end bosses. Rating must be 8 or better. This finish must also comply with the final protective finish procedure IAW 12420325 Method 7.

PROCEDURE – 12420325

Method 7: Surfaces that do not have a polyurethane topcoat but must have a protective corrosion resistant finish for interior and exterior exposure.

Finish: The component shall be corrosion resistant to high humidity, Salt Spray, Road De-Icing chemicals and Atmospheric contamination. No perforation or other damage caused by corrosion shall require repair or replacement of parts. The corrosion prevention method shall not require actions (Beyond the normal washing and replacement of damaged finish) to keep the corrosion prevention in effect. The color of the finish is optional or within the specification of the component. This will insure material/finish to ten (10) years in military environment.

Application: IAW best commerical/paint manufacture’s method color optional: #34094 Lusterless #383 Green or #37030 Lusterless black are preferred.

9432 REVA Finish P513.1M per Spec. MIL-F-14072 Treat per MIL-DTL-5541 Class 1A. Prime with zinc chromate primer per TT-P-1757-1, Color Y. Finish per MIL-C-22750, semi gloss olive drab epoxy (Color No. 24084), with a dry film thickness of 0.0254mm (1mil) to 0.0381mm (1.5mils).

9433 Electroless Nickel plating per AMS 2404, Class 1.

9434 CARC tan exterior paint for aluminum, per Raytheon G781772, Type IX, Grade 1. Components already finished per Barry Finish 920 do not require additional application of chromate per section 3. Handling damage to finish 920 may be repaired by brush or by pretreatment wash primer per section 3.1, grade 1 note.

Recommended materials for this finish are Sherwin-Williams primer part #E90H226 (Barry #67005816) catalyst part #V93V227 (Barry #67005815), and finish paint part #F93H107 (Barry #67005813). Use only MIL-T-81772 type 1 reducer. Reducers must
be polyurethane grade. All materials must be from the Qualified Product List, and full QPL certification is required with each shipment.

9435 Zinc-Cobalt plate per ASTM B840 class1, type D, grade 6.

9436 Zinc plate .0003 to .0004 thick per ASTM B633, Class FE/ZN 8, Type III, w/trivalent chromium. USE OF HEXAVENT CHROMIUM IS PROHIBITED.

9437 Chromate conversion coat per ASTM B-449. Color to be yellow/bronze unless otherwise specified. When applied to 6061-T6 wrought or 360 die cast aluminum alloys, must pass 96 hours neutral salt spray per ASTM B-117 with no corrosion.

9438 Mask all exposed elastomer sections prior to finishing. Apply corrosion inhibiting epoxy primer per DOD-P-23377, 0.001-0.0015 inch thick. Apply green 383 CARC per MIL-C-46168, 0.0018-0.005 inch thick.

9439 Prime with Amerlock 400, Primer Epoxy, White, 0.0001 to 0.003 thick coat with Amercoat 450HS, Top Coat, White, 0.001 to 0.003 thick. Suggested source, Ameron Inc., Protective Coating Division. Apply and cure per Manufacturer’s directions. Suggested paint vendor: Valley Precision, Burbank, CA.

9440 Base finish: Aluminum Conversion coating per MIL-DTL-5541, Class 1A base finish. Prime with AMERLOCK 400, Primer Epoxy, White, 0.001 to 0.003 thick. Coat with AMERCOAT 450HS, Top Coat, White, 0.001 to 0.003 thick. Suggested source, Ameron Inc., Protective Coating Division. Apply and cure per manufacturer’s directions. Suggested paint vendor: Valley Precision, Burbank, CA.

9441 REVA Metal Prep and Painting of Navy Mounts per General Dynamics Electric Boat Division Specification 3092. A copy of specification 3092 can be obtained from the Technical Review Group.

A). Prior to molding, blast, degrease and phosphate metal components.
B). After molding, remove any loose flash and blast exposed metal surfaces. The blast profile shall be at least 1 mil deep, but not too exceed 3mils deep.
C). Paint all exposed metal surfaces.
D). The paint system shall be applied to the ID of bolt holes and internal surfaces of sleeves but only to the extent that no bare metal exists. Paint thickness shall not adversely affect mount assembly.
E). The finish shall be a two coat epoxy paint system in accordance with either MIL-P-24441, Type IV (formula 150 green primer and appropriate formula topcoat for color) or a two coat MIL-P-23236, Type IV, Class 1, Grade B epoxy paint system.
Topcoat color shall be black and approximately the same as MIL-P-24441, Type IV, Formula 153, which matches FED-STD-595 color chip #37038.

F). The recommended primer is MIL-DTL-24441C, Type 4, 150 Green Primer, approximately 3 mils thick.

G). The recommended topcoat is MIL-DTL-24441C, Type 4, 153 Black, approximately 3 mils thick.

H). The Primer and Topcoat can be purchased from Ameron International Performance Coating & Finishing Group. The Primer is typically provided in a 5 gallon bucket containing Component A (p/n 67005763) and Component B (p/n 67005764) premixed. The Topcoat is typically provided in a 5 gallon bucket containing Component A (p/n 67005761) and Component B (p/n 67005762) premixed.

I). The total minimum dry film thickness shall be 6 mils. To verify the setup, measure the thickness on at least one part in accordance with ASTM D1186 on both sides of the flange and both sides of a washer.

J). For mounts with rated load less than 450 pounds, paint may uniformly overlap the rubber by no more than 1/16 inch. Paint overlap in excess of 1/16 inch shall be irregular up to but not exceeding 1/8 inch total.

K). For larger mounts rated for 450 pounds or larger, uniform paint overlap of 1/8 inch is acceptable. Paint overlap in excess of 1/8 inch shall be irregular up to but not to exceed ¼ inch total.

## 9442 B
Modified from AAAV Finish Method 101 – ALUMINUM, INTERIOR

1. Buff, blast or machine all surfaces to remove oxide.
2. Pretreat with Alodine 5700 or Navarc 818 or NAVAIR Trivalent Chromium Pretreatment. Barry # 67005770
3. Mark or plug all holes. 0.05 inch (1.27 mm) radial paint free area allowable around holes.
4. Prime with MIL-P-85582 Type II, Class N epoxy primer, dry film thickness 0.015 to 0.023 mm (0.6 to 0.9 mil) or MIL-P-53022 primer, dry film thickness 0.025 to 0.063mm (1 to 1.5 mil). Recommended for MIL-P-53022 use Sherwin-Williams E90H226 and V93V227, Barry 67005721 and 67005722.
5. Topcoat with MIL-PRF-22750 sea foam green epoxy, Color #24533. Dry film thickness shall be 0.033 to 0.043 mm (1.3 to 1.7 mil). Recommended use Sherwin-Williams F92G227, Barry 67005765.

## 9443
1) Chem. film per MIL-DTL-5541, Class 1A
2) 2 Coats of Epoxy Primer per MIL-P-85582.
3) Paint Finish per MIL-C-22750. Color shall be Number 17925 White per FED-STD-595. The first use of this finish was the Lockheed – Boeing Ft. Worth F22 Program

## 9444
Black E-coat per Bombardier Recreational Products spec 1739:
Material: PPG Powercron 590 or 640
Substrate: Steel
Pretreat using a) zinc phosphate, thickness 150 to 350 mg/sq. ft or b) zinc cobalt per Bombardier Recreational Products spec 1843
Dry film thickness 0.5 to 0.9 mil
All other requirements per Bombardier Recreational Products spec 1739

1). Surface preparation of mounting plates shall consist of masking all faying surfaces, threads, label plates, etc., required to be left unpainted.
2). Dry abrasive blast per ANSI A159.1, No. 6, commercial blast cleaning (SSPC-SP6) or equal, to min. 25 micron (0.001) profile.
3). As soon as practicable after cleaning but prior to the onset of any rust bloom to surface, apply one coat of epoxy primer per MIL-P-24441/20, formula 150, Type 3, dry film thickness (DFT) 0.002 Mil.
4). Intermediate and topcoat, epoxy polyamide enamel per Mil-P-24441/21, formula 151, Type 3, DFT 0.002 Mil each.
5). Total DFT of complete paint system is 0.006 Mil.

9446 REV A

Apply a 1.0 - 2.0 MIL thick coat of epoxy polyamide primer per MIL-PRF-23377.
Top coat shall be 1.8 – 2.4 MIL thick paint film of aliphatic polyurethane coating per MIL-DTL-53039, color TAN 686A, color number 33446 conforming to FED-STD-595. Thinner for primer and top coat shall be per MIL-T-81772, Type 1.
Exterior marking shall be done with the same paint except the color shall be BLACK 37030 per FED-STD-595.

9447
1. Prepare surfaces by masking all threads and areas designated as coating free.
2. Clean all areas to be coated with a chlorinated solvent and a slightly abrasive pad or a rough cloth.
3. Rinse cleaned surfaces with acetone or MEK.
4. Prime surfaces to be coated with Dow Corning 1200 primer per manufacturer's recommendations. Primer thickness need not be measured.
5. Allow primer to dry for at least 1 hour.
6. Paint surfaces by brush or spray with Dow Corning 92-007 silicone coating per manufacturer's recommendations.
7. Total coating thickness to be .006 ± .002.

9448 B
Finish IAW Army drawing 12469113 or 12469120. Top Coat color shall be black 37030. Process and materials listed below are recommendations ONLY, actual finish certification must be to latest rev of Army drawings.

This is a multi-step finish as follows:
1. Surface cleaning to remove all moisture, oils, greases, salts, corrosion, dirt and soils to a white metal condition. If the primer is to be applied more than four hours after cleaning, a zinc phosphate treatment is required (see Army drawings).
2. Organic Zinc-Rich primer, must have a minimum 80% content by weight of zinc particles. Dry film thickness shall not be less than 64 microns. Zinc dust pigment must conform to ASTM D-520, Type 1, and shall be IAW SSPC-Paint 20, Zinc-Rich Primers Type II, "Organic". Recommended material Sherwin-Williams single package E90GC101. Barry 67005829.
3. Epoxy primer IAW MIL-P-53022 or MIL-P-53030. Dry film thickness to be 40 microns minimum. Recommended material Sherwin-Williams E90H226 and V93V227, Barry 67005721 and 67005722.

4. Topcoat with Polyurethane IAW MIL-C-53039, color black 37030. Dry film thickness to be 46 microns minimum. Recommended material Sherwin-Williams moisture cured single package F93B102, Barry 67005800.

5. Coating adhesion test shall be IAW TT-C-490 and be performed once per day minimum.

6. Parts coated IAW these drawings shall meet the finish performance requirements of drawing 12469122.

9449  Clean and degrease surfaces to be painted. Apply one coat of Chemflash 500.

9450 A Clear hardcoat anodize type 3, class 1 of Mil-A-8625
Vacuum impregnation using Loctite PMS 10E, single cycle.

9451 Zinc Phosphate: 150mg/ft\(^2\) min. to 372mg/ft\(^2\) max.

9452 Phosphoric Anodize and Prime with Cytec BR127 IAW ASTM-D3933.
Part shall be individually wrapped in kraft paper and sealed in 6 mil, black polyethylene bags.
Store in an environmentally controlled area.

Handling – All parts during and after processing and before bonding should be handled as little as possible and only with clean, lint-free cotton or nylon fabric gloves. If it becomes necessary to handle or touch parts, contact should be limited to surfaces not be bonded.

9453 A ASTM B 841 – 99 zinc / nickel plating specification (ASTM B 841 – 99), and classification 4.2.1 Type A – With Colorless (blue bright) conversion coating, Grade 10. Minimum thickness of zinc / nickel coating shall be no less than 10 microns. Plating specification has been modified for a minimum and maximum Nickel content of 12% and 15%, respectively.

9454 This finish is the cleaning and organic zinc rich primer portions of Barry Finish 9448 only and is intended to be used in conjunction with Barry finish 9455 for a complete coating system.

Finish IAW Army drawing 12469113 through paragraph 4, section C or 12469120 through paragraph 4, section B. Process and materials listed below are recommendations ONLY, actual finish certification must be to latest rev of Army drawings.

This is a multi-step finish as follows:

1. Surface cleaning to remove all moisture, oils, greases, salts, corrosion, dirt and soils to a white metal condition. If the primer is to be applied more than four hours after cleaning, a zinc phosphate treatment is required (see Army drawings).

2. Organic Zinc-Rich primer, must have a minimum 80% content by weight of zinc particles. Dry film thickness shall not be less than 64 microns. Zinc dust pigment must conform to ASTM D-520, Type 1, and shall be IAW SSPC-Paint 20, Zinc-Rich Primers Type II, “Organic”. Recommended material Sherwin-Williams single package E90GC101, Barry 67005829

3. In the case of finish per drawing 12469113, heat cure per paragraph 4, section C.
9455 A This finish is the epoxy primer and CARC top coat portions of Barry Finish 9448. This finish is intended to be applied after Barry finish 9454 for a complete coating system.

Finish IAW Army drawing 12469113 or 12469120 primer and top coat sections only. Top Coat color shall be black 37030. Process and materials listed below are recommendations ONLY, actual finish certification must be to latest rev of Army drawings.

This is a multi-step finish as follows:

1. Lightly scuff surface of Zinc Rich primer finish (Barry 9454) and wipe clean with solvent.
2. Epoxy primer IAW MIL-P-53022 or MIL-P-53030. Dry film thickness to be 40 microns minimum. Recommended material Sherwin-Williams E90H226 and V93V227, Barry 67005721 and 67005722.
3. Topcoat with Polyurethane IAW MIL-DTL-53039, color black 37030. Dry film thickness to be 46 microns minimum. Recommended material Sherwin-Williams moisture cured single package F93B102, Barry 67005800.
4. Coating adhesion test shall be IAW TT-C-490 and be performed once per day minimum.
5. Parts coated IAW these drawings shall meet the finish performance requirements of drawing 12469122.

9456 REVA Zinc Plate Per ASTM B633, FE/ZN 12 (.0005 inch thick) Type III (Clear). Final finish with Trivalent Chromate only. No Hexavalent Chromate allowed. This finish is to be RoHS compliant. Finished parts must be supplied with Certification of the Zinc and Trivalent Chromate processes clearly indicating RoHS compliance.

9457 REVA Electroless nickel plate .0005” minimum thick per MIL-C-26074, Class 1, Grade B, or equivalent per AMS2404, Teflon Impregnated, no relief bake necessary, per Section 3.4 allowed.

9458 Passivate per ASTM A967.

9459 After molding before assembly apply primer per MIL-P-53022, TYPE II (Sherwin Williams E90H226 and V93V227, Barry 67005721 and 67005722) or MIL-P-53030 IAW MIL-DTL-53072, 1.2 MIL (30 μM) minimum dry film thickness. Overspray on elastomer section allowable but not desired.

9460 Aluminum conversion coating per MIL-DTL-5541, Type II, Class 1A.

9461 Chemically coat per ASTM B449, Class 3.

9462 Zinc Phosphate per Barry Finish 900 then apply “vanishing oil” or any light non-wax, non-preservative, RoHS compliant, petroleum oil for oxidization protection during shipping. Do not use new or used motor oil or any oil containing lead.

9463 CARC finish per Raytheon G781772, Grade 3. Type (color) to be determined IAW latest revision of Raytheon drawing
13552762. Finish supplier to contact Barry Controls purchasing for a copy of the latest drawing revision. Finish MUST BE APPLIED BY A RAYTHEON APPROVED SUPPLIER. (Reference only: drawing 13552762 rev E specified Type IX “Desert Sand” (Tan 686A)).

9464 Steel grit blast all over. Phosphate per TT-C-490, Type I.

9465 Prime with one coat 0.002 mil thick of epoxy Polyamide primer per MIL-DTL-24441/29, formula 150, type 4. Finish with one coat 0.004 mil thick of epoxy polyamide enamel per MIL-DTL-24441/30, formula 151, type 4.

9466 All exposed structural components to be finished as follows:

Phosphate dipped per TT-C-490, Type I or grit blasted all over. Painted with epoxy paint per MIL-DTL-24441/29 primer .002 inch (2 Mils) thick and MIL-DTL-24441/31 topcoat, color white .004 inch (4 Mils) thick.

9467 Mask as specified on drawing.

Prime one coat epoxy primer per MIL-PRF-23377, Type I, Class N. Use primer within 8 hours of mixing. Dry film thickness to be 1.0 mil ± 0.2 mil. Dry for at least 2 hours at room temp or 30 minutes at room temp followed by 30 minutes at 135 ± 5 F.

Topcoat with polyurethane chemical-agent-resistant paint per MIL-DTL-53039, color green per FED STD 595, #34094. Dry film thickness to be 2.0 mil ± 0.2 mil. Dry for at least 48 hours at room temp or 15 minutes at room temp followed by 45 minutes at 130 ± 10 F.

Periodically test for adhesion per Lockheed Martin spec 79P020007, Section 4.5.2.1 or per ASTM D3359, Method B, 6-line pattern, 2mm spacing.

Reference: Lockheed Martin spec 79P050000 Code 4001 and Code 4102, Lockheed Martin spec 79P020007
Note: This finish must be applied by a Lockheed Martin approved painting supplier. Barry Controls is not a qualified supplier.

9468 Fluorosilicone coating per Lockheed Martin spec 79771699

Clean exterior surfaces to remove dirt and oil (isopropyl alcohol suggested). Do not allow liquid to pool. Dry.

Mask as specified on drawing.

Attach witness sample tags, 2/lot minimum.

Spray on coating, Bryflex HTF-1. Coating thickness to be .0001-.0002 inches.
Cure 20 minutes at 210 F +/- 10

Visually inspect 100%. Color must be clear to milky. No delamination or pitting shall be visible at 1.75X magnification

Test adhesion on witness sample tags per ASTM D-3359 Method B

9469 Passivate per SAE-AMS2700.

9470 Surface clean per SSPC-SP 6/NACE No. 3, Commercial Blast Cleaning. Surface shall be free of all visible oil, grease, dust, dirt, mill scale, rust, coating, oxides, corrosion products, and other foreign matter. Apply Organic Zinc-Rich primer, must have a minimum 80% content by weight of zinc particles. Dry film thickness shall be 2.5 – 4.0 mil thick. Zinc dust pigment must conform to ASTM D-520, Type 1, and shall be SSPC-Paint 20, Zinc-Rich Primers Type II, “Organic”. Recommended material Sherwin-Williams single package E90GC101. Barry 67005829.

9471 Surface clean per SSPC-SP 6/NACE No. 3, Commercial Blast Cleaning. Surface shall be free of all visible oil, grease, dust, dirt, mill scale, rust, coating, oxides, corrosion products, and other foreign matter. Hot dip galvanize, 2.0 – 3.0 mil thick.

9472 Surface clean per SSPC-SP 6/NACE No. 3, Commercial Blast Cleaning. Surface shall be free of all visible oil, grease, dust, dirt, mill scale, rust, coating, oxides, corrosion products, and other foreign matter. Apply Inorganic Zinc-Rich coating, must have a minimum 80% content by weight of zinc particles. Dry film thickness shall be 2.0 – 4.0 mil thick. Recommended material Sherwin-Williams Zinc Clad XI Water Based Inorganic Zinc-rich Coating (Product # B69V00011).

9473 REV B One coat of BMS 10-11 Type I primer per BAC 5736.

9474 Procedure for POST MOLD application or touch-up of aluminum conversion coating per MIL-DTL-5541, Class IA (Finish 920). Method designed to minimize damage to molded silicone and associated adhesives.
1. Clean with Aluminum Safe Cleaner (30 to 90 seconds)
2. Rinse thoroughly
3. Dip in chromate conversion solution-chromic acid bath- Alodine 600 RTU or Oakite equivalent. (3 to 15 minutes) Depends on coating color and speed.
4. Rinse thoroughly
5. Room Temperature Dry or accelerated Dry with hot air

9475 REV A Paint per Raytheon specification H372287, Type I, Grade 2 except in threaded holes as shown on drawing. Mask internal threads prior to painting. Threaded holes to be zinc primed only per TT-P-645.
Must be performed by a Raytheon approved supplier. Latest revision of Raytheon specification shall be provided with purchase order.

9476 Trivalent chromium conversion coating per MIL-DTL-5541, Type II, Class 3.

Finish must be applied by a Lockheed Martin approved finish supplier. See BDS 2079 or Lockheed Martin spec 79P000010 for requirements.

Ref: Lockheed Martin spec 79P050000 Code 2005

Note: This is the low electrical resistivity variation of trivalent chemical conversion coating.

9477 Trivalent chromium conversion coating per MIL-DTL-5541, Type II, Class 1A.

Finish must be applied by a Lockheed Martin approved finish supplier. See BDS 2079 or Lockheed Martin spec 79P000010 for requirements.

Ref: Lockheed Martin spec 79P050000 Code 2004

9478 Passivate in accordance with ASTM A967.

Sample and test the finish in accordance with AMS2700, Annex A, Method 100 or 101. Method 102 may be used for ferritic 400 series alloy steels with greater than 16% chromium, austenitic stainless steels, and precipitation hardened steels. The lot may be tested 100% in lieu of sampling.

See BDS 2079 for further details.

Ref: Lockheed Martin spec 79P050000, Code 2401

9479 Mask as specified on drawing.

Prime one coat epoxy primer per MIL-PRF-23377, Type I, Class N. Use primer within 8 hours of mixing. Dry film thickness to be 1.0 mil ± 0.2 mil. Dry for at least 2 hours at room temp or 30 minutes at room temp followed by 30 minutes at 135 ± 5 F.

Topcoat with polyurethane chemical-agent-resistant paint per MIL-DTL-53039 Type I or Type II or MIL-DTL-64159 Type I or Type II, color tan per FED STD 595, #33446. Dry film thickness to be 2.0 mil ± 0.2 mil. Dry for at least 48 hours at room temp or 15 minutes at room temp followed by 45 minutes at 130 ± 10 F.

See BDS 2079 for other requirements such as adhesion testing and solvent resistance testing.

Note: This finish must be applied by a Lockheed Martin painting supplier approved for this finish. Barry Controls is not a qualified supplier.

9480 Electroless nickel plate in accordance with SAE-AMS-C-26074 or SAE-AMS-2404, 0.001 inch minimum thickness. Phosphorous content of the nickel plating shall not exceed 5%.

9481 REVA Sherwin-Williams Metalastic DTM Acrylic Modified Enamel Black B55BZ600
  WFT 5 – 8 mils
  DFT 3 – 5 mils

9482 REVA Primer Sherwin Williams
  Zinc Clad III HS 100 Organic Zinc-Rich Epoxy primer
  WFT 1.3 – 3.3 mils
  DFT 0.8 – 2.0 mils
  Per Siemens specification STS-ENS-333.10872

9483 REV A Primer Sherwin Williams
  Zinc Clad III HS 100 Organic Zinc-Rich Epoxy primer
  WFT 5.0 – 8.0 mils
  DFT 3.0 – 5.0 mils

  Top coat Sherwin Williams
  Macropoxy 646-100 fast cure epoxy
  WTF 13.5 – 16.5
  DFT 10.0 – 12.0 mils

  Per Siemens specification STS-ENS-333.10872

9484 Pre-treat as per MIL-DTL-5541 Class 1A;
  Prime and paint all outside surfaces and edges per MIL-F-14072;
  Prime per MIL-P-23377;
  Final paint film: forest green per MIL-C-46168.

9485 REV A Tin plate per ASTM B545-97, Class D (.0008-.002 thick). Matte finish.

9486 Passivate Per ASTM A967 or SAE AMS2700 Method 1 Type 6 or 7 or Method 2
Coat per TMS-9009 Class 2.
The initial gloss @ 60 degrees, 80 minimum is waived.
Color to be black.

TECTYL 506-EH WD
Apply with brush.

Staburags NBU 30
Apply with brush.

Clean: IAW TT-C-490 METHOD OPTIONAL
Pretreat: IAW TT-C-490, TYPE I
Optional: IAW TT-C-490, TYPE III, IAW DOD-P-15328
DRY FILM THICKNESS IAW MIL-DTL-53072
Primer: IAW MIL-P-53084 DRY FILM THICKNESS 1.0-1.2 mil
Optional: IAW GM9984070, GM9984017, GM9984094 OR A-A-52474
COLOR SEMIGLOSS GRAY OR BLACK
Topcoat: IAW MIL-DTL-53039 OR MIL-DTL-64159
DRY FILM THICKNESS IAW MIL-DTL-53072
COLOR #34094 LUSTERLESS #383 GREEN

OR:
Clean: IAW TT-C-490 METHOD OPTIONAL
Pretreat: IAW TT-C-490, TYPE I
Optional: IAW TT-C-490, TYPE III, IAW DOD-P-15328
DRY FILM THICKNESS IAW MIL-DTL-53072
Primer: IAW MIL-P-53022 OR MIL-P-53030
DRY FILM THICKNESS IAW MIL-DTL-53072
COLOR #27875 SEMIGLASS WHITE
Topcoat: IAW MIL-DTL-53039 OR MIL-DTL-64159
DRY FILM THICKNESS IAW MIL-DTL-53072
COLOR #34094 LUSTERLESS #383 GREEN

Clean: IAW TT-C-490 METHOD OPTIONAL
Pretreat: IAW TT-C-490, TYPE I
Optional: IAW TT-C-490, TYPE III, IAW DOD-P-15328
DRY FILM THICKNESS IAW MIL-DTL-53072
Primer: IAW MIL-P-53084 DRY FILM THICKNESS 1.0-1.2 mil
Optional: IAW GM9984070, GM9984017, GM9984094 OR A-A-52474
COLOR SEMIGLOSS GRAY OR BLACK
Topcoat: IAW MIL-DTL-53039 OR MIL-DTL-64159
DRY FILM THICKNESS IAW MIL-DTL-53072
LUSTERLESS #686 TAN

OR:
Clean: IAW TT-C-490 METHOD OPTIONAL
Pretreat: IAW TT-C-490, TYPE I
Optional: IAW TT-C-490, TYPE III, IAW DOD-P-15328
DRY FILM THICKNESS IAW MIL-DTL-53072

HUTCHINSON
82 South Street
Hopkinton, MA 01748
Tel: 508-417-7000 Fax: 508-417-7224
Primer: IAW MIL-P-53022 OR MIL-P-53030
DRY FILM THICKNESS IAW MIL-DTL-53072
COLOR #27875 SEMIGLOSS WHITE

Topcoat: IAW MIL-DTL-53039 OR MIL-DTL-64159
DRY FILM THICKNESS IAW MIL-DTL-53072
LUSTERLESS #686 TAN

Apply one coat MIL-PRF-23377 Epoxy Primer Type I, Class C1 or C2 in accordance with Goodrich Specification PS2017 to Aluminum Surface not covered by the Elastomer or Bonding Primer. Overspray is permissible on adjacent surfaces.

Anodize per MIL-8625, Type I - Chromic Acid process or Type II - Sulphuric Acid process, except using clear water seal instead of Dichromate seal. Unless otherwise specified on drawing, anodize is to be Class 1 per MIL-A-8625 non-dyed. Finish with 2 coats of BMS 10-11 Type I primer per BAC 5736.

Zinc Plate Per ASTM B633, FE/ZN 12, SC 3, Type VI. Final finish with Yellow Trivalent Chromate. No Hexavalent Chromate allowed. This finish is to be RoHS compliant. Finished parts must be supplied with Certification of the Zinc and Trivalent Chromate processes indicating RoHS compliance.

ELECTROLESS NICKEL PLATE PER SAE AMS2404, CLASS 3. PHOSPHORUS CONTENT 10 PERCENT MINIMUM. FINAL PLATING THICKNESS .0010-.0020. PLUG THREADED HOLES BEFORE PLATING.

Chromate coating per MIL-C-17711, color yellow or gold. Must be RoHS compliant.

Kalgard Black 094-9218PF 1.8-2.2 mil dry film thickness.

Zinc plate per ASTM B633, Class FE/ZN 12, Type II, with trivalent chromate. USE OF HEXAVALENT CHROMIUM IS PROHIBITED. This finish is to be RoHS compliant.

Aluminum conversion coating per MIL-DTL-5541, Type II, Class 3 RoHS compliant.

Anodize per MIL-A-8625, Type 1B. Supplemental treat with solid film lube per SAE AS5272, applied per SAE AS5528. The solid film shall be applied in accordance with AS5528 for Type 2 except that the baking requirement of paragraph 3.2.8 shall be 325°F ± 10°F for two hours after parts have stabilized at 325°F. Paragraphs 3.4.4 and 3.4.5 of AS5272 shall not apply to items baked at 325°F. All paragraphs in AS5528 that reference applied film thickness shall be amended to require a thickness of .0005 to .0010 (0.013 to 0.025mm). Reference General Dynamics Specification # 119A2115.
9501 REVA
- Primer:
  PAINT-10033 (Arkote 31)
  (For Reference only WFT Mean thickness: 3.9 mils to 5.5 mils)
  DFT Mean thickness: 1.6 mils to 2.4 mils
- Top Coat:
  PAINT-20020 (Arkote 110 HES noir)
  (For Reference only WFT Mean thickness: 5.5 mils to 7.9 mils)
  DFT Mean thickness: 2.4 mils to 5.5 mils
Total DFT mean thickness comprised between 4 mils and 7.9 mils
Gloss 60±20%
Refer to Paint control plan for other requirement such as adhesion testing.

9502
- Primer:
  PAINT-10033 (Arkote 31)
  (For Reference only WFT Mean thickness: 3.9 mils to 5.5 mils)
  DFT Mean thickness: 1.6 mils to 2.4 mils
Refer to Paint control plan for other requirement such as adhesion testing.

9503
Strippable Plastic Coating Type II Grade C Blue.
Applied by dipping in hot melt tank.

9504

9505

9506
Zinc Plate Per ASTM B633 Class FE/ZN 12 Type V Hexavalent Chromate is prohibited. Use of a sealing coat is prohibited. This finish is to be RoHS compliant.

9507
Lord Corp. Aeroglaze 9741/9700. Mix ratios between 5:1 and 20:1 by weight, or 3:1 and 12:1 by volume.

9508
- Primer:
  PAINT-10038 (PPG Amerlock 2 VOC, gray anthracite RAL 7016)
  DFT Mean thickness: 5 mils to 9 mils
Refer to Paint control plan for other requirement such as adhesion testing.

9509 REVA
- Primer:
  PAINT-10039 (PPG Amerlock 2 VOC, beige red RAL 3012)
  DFT Mean thickness: 0.8 mils to 2 mils
Refer to Paint control plan for other requirement such as adhesion testing.

9510
RoHS compliant alkaline Zinc-Nickel finish, 12%-15% Nickel content, minimum thickness of Zinc-Nickel coating to be 12 microns, clear or black trivalent
chromate conversion coating. Bake for hydrogen embrittlement relief per ASTM B 850.

9511 Magni 565 - Chrome free duplex coating. RoHS compliant.

9512 Zinc corrosion protection according to GM specification GMW3044 Sub-specification 6K96/48

9513 High solids epoxy coating, color light grey, which meets 250-500 hour salt spray requirement per ASTM B117.

9514 Zinc corrosion protection according to GM specification GMW3044 Sub-specification 8K240/120 with passivation.

9515 Mask areas per drawing. Apply two coats of zinc chromate primer per TT-P-1757, Color Y.

9516 -Primer:
PAINT-10042 (PPG Amerlock 2 VOC, jet black RAL 9005)
DFT thickness: 5.0 mils to 9.0 mils
Refer to Paint Control plan for other requirement such as adhesion testing.

9517 PASSIVATE PER AMS2700 METHOD 1 TYPE 8 CLASS 2.